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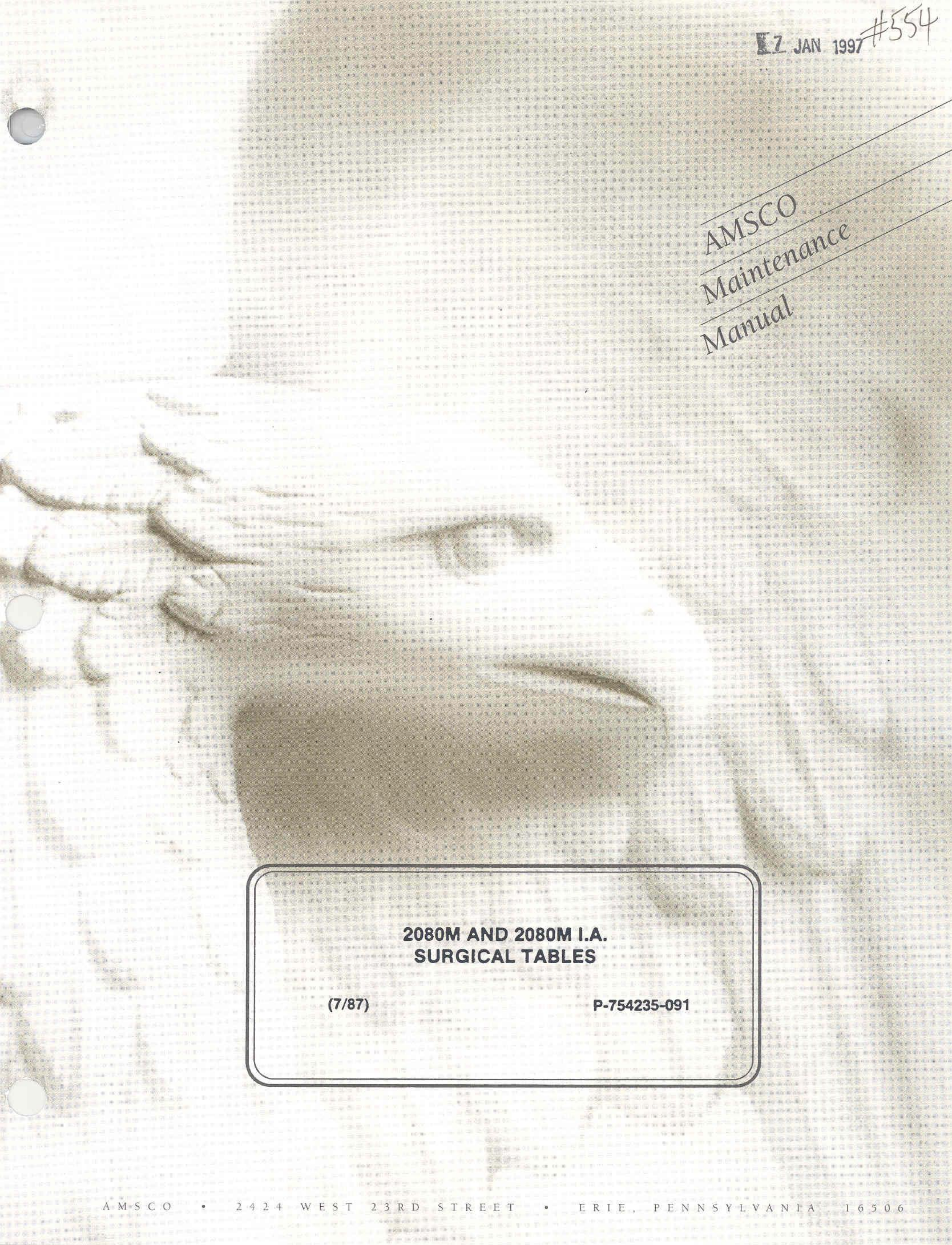

AMSCO
Maintenance
Manual

2080M AND 2080M I.A.
SURGICAL TABLES

(7/87) P-754235-091

AMSCO • 2424 WEST 23RD STREET • ERIE, PENNSYLVANIA 16506

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**See Note 1 on Parts List.*

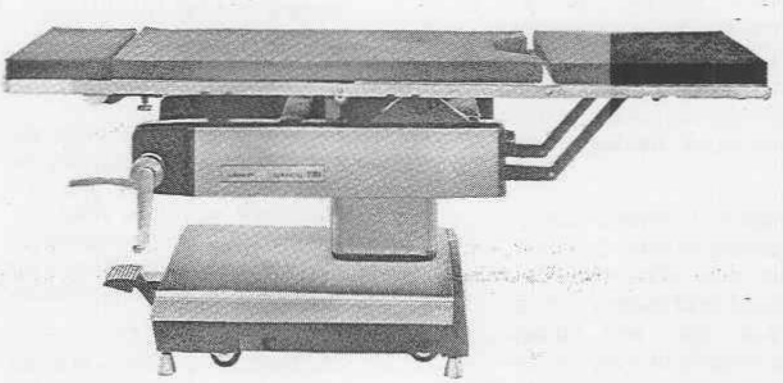
Service Bulletin Number						

AMSCO

2080 Surgical Table Series

2080 SERIES*
Major Surgical Table
• *manual control*

TECH DATA



*patent pending

Typical only — some details may vary.

APPLICATION

This Table provides flexible articulated posturing of the surgical patient, assuring maximum operative convenience.

DESIGN AND CONSTRUCTION

General. The Table complies with the *Radiation Control for Health and Safety Act* of October 18, 1968 and is hydraulically raised and lowered. Hand cranks, geared for easy positioning, provide tabletop articulation. It is listed by Underwriters Laboratories, Incorporated.

Base is cast iron with textured-enamel finish. The top is enclosed by a welded, stainless-steel cover that also forms a shroud for the lower portion of the pedestal. A swivel caster and height-adjustable floor lock at each corner are actuated by a single pedal. Both are electrically conductive, conforming with applicable requirements of NFPA's publication, *Flammable Anesthetics Code.* The base provides comfortable toe space on both sides as well as space to freely insert a flat-blade Mayo stand. The base also contains the hydraulic system. A NFPA-approved patient grounding receptacle is provided at foot-end of base.

Pedestal includes tabletop lift cylinder and support column with bearing-mounted saddle frame. These are fully enclosed by stainless-steel, telescoping shrouds. Each shroud is one-piece construction to ensure against foreign matter entering the elevating mechanism.

Superstructure includes bearing-mounted gears for positioning and articulating the tabletop. The frame is cast aluminum finished with textured-enamel paint. The superstructure is bearing-mounted to the elevating mechanism. Indicators show degree of lateral tilt and Trendelenburg. Positioning mechanisms are fully enclosed by stainless-steel covers to prevent enmeshment of drapes.

Tabletop. The 20-inch (508-mm) wide tabletop (see page 3) is divided into four hinged sections: head, back, seat, and foot. Each section is cast aluminum (back, seat and foot sections are covered by stainless-steel veneer). Drilled holes are included for the optional radiographic top. Stainless-steel side rails, notched to receive optional accessories, extend the full length. Mounting hardware and a full

THE SELECTIONS CHECKED BELOW APPLY TO THIS EQUIPMENT

☐ Table with 2'' (51mm) thick Pad

☐ Table with Radiographic Top and 1'' (25mm) thick Pad

☐ Table with Radiographic Top and 2'' (51mm) thick Pad

☐ Accessories *(see separate product literature)*

Item No. ____________________
Location(s) ____________________
____
____

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complement of optional accessories are available ... see separate product literature.

The foot and back sections are safely supported by two hinged, steel lever arms.

The tabletop is bearing-mounted to the superstructure at the seat section. The seat and foot sections include a perineal cutout for full access to the patient and to accommodate the optional transuretheral drain tray. The tabletop (with exception of the head section) is positioned by hand cranking. The head section is secured by a manual, spring-loaded, ratchet mechanism. The head section may also be removed and positioned longitudinally to extend table length as much as 6 inches (152mm), or it may be attached to the foot section for procedures requiring extended foot support. A Velcro® (Velcro Corporation) tape strip on the longitudinal centerline of the head, back and foot sections permits instant application and removal of mattress pads ... no other pad-fastening devices are required.

An independently operated kidney elevator is centrally located between the back and seat sections. The elevator is raised and lowered by a crank and dual rack and pinion mechanism, operating in conjunction with the gearing and jointed drive shaft. The kidney elevator is cast aluminum covered by stainless-steel veneer.

Optional **Radiographic Top** is constructed of permeable phenolic and is electrically conductive. It mounts on full width and length of tabletop. The radiographic top complies with the *Radiation Control for Health and Safety Act* of October 18, 1968. A 14x17 inch (356x432mm) radiographic cassette can be inserted from head- or foot-end; 12x14 inch (305x356mm) radiographic cassette, from side, head-end or foot-end. (Radiographic cassettes are not furnished by AMSCO.)

OPERATING CONTROLS

Hand cranks and selectors requiring operator attention are all at the head-end of the table, easily accessible to the anesthetist.

Foot Pedals are easily actuated and clearly identified. They include:

- **LOCK** — to engage either the casters or locks with the floor.
- **RAISE/LOWER** — to raise or lower the tabletop.

Tabletop Positioning Controls are mounted at a convenient height on the superstructure ... arranged for simple, accurate actuation. After setting the selector for the desired movement, the tabletop is positioned by operating the crank handle. Selections include:

- **TRENDELENBURG** — to lower or raise the head-end of the superstructure from horizontal, to achieve Trendelenburg (head down) and reverse Trendelenburg (head up). Control is on left side of head end.
- **BACK** — to lower or raise the back section.
- **SIDE** — to laterally tilt the superstructure to the right or left.
- **FOOT** — to lower or raise the foot section.
- **FLEX** — to simultaneously position the back and seat sections, so as to achieve an inverted "V" (flex) or "V" (reflex) position.

ACCESSORIES

See separate product literature.

MATERIAL SPECIFICATIONS

General. Materials not definitely specified herein are of the best quality routinely employed for the purpose in the industry. They have been selected to help enhance the safety, serviceability and appearance of the finished product.

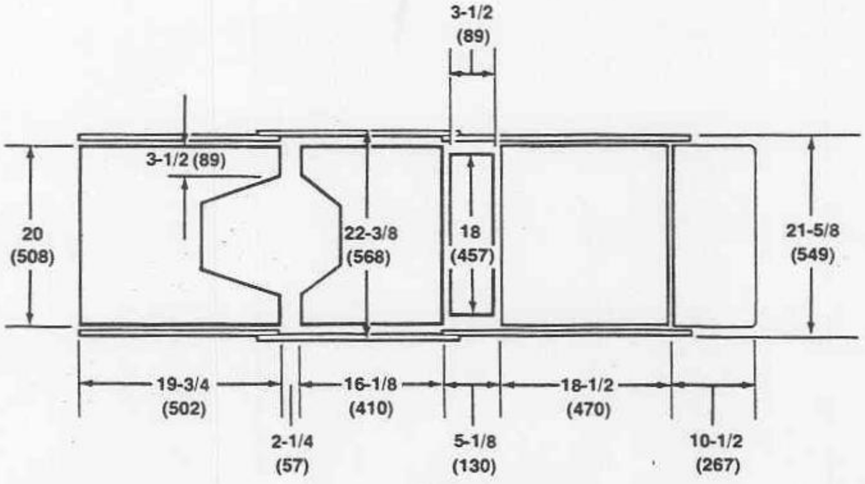
Finish. Exposed stainless steel (conforming with ASTM Specification A 167), aluminum and chromium-plated surfaces are polished. Cast iron and carbon-steel exterior surfaces are degreased, phosphatized and coated with corrosion-resistant primer followed by two spray coats of textured-enamel paint. The finish is then oven baked.

PERFORMANCE CAPABILITIES

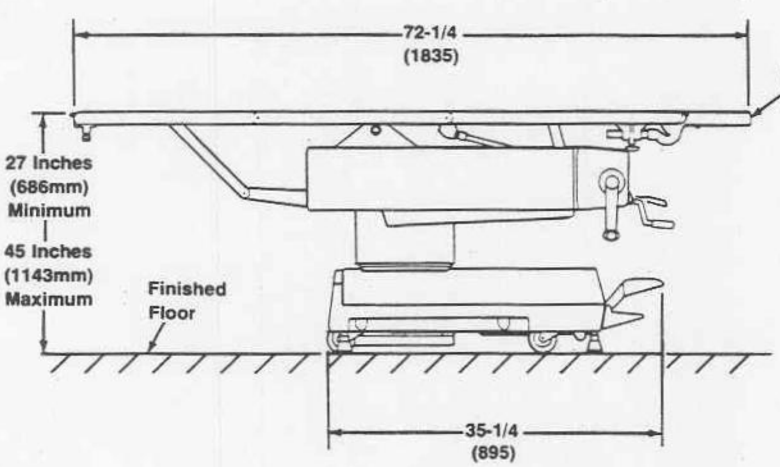
When operated with a 300-pound (136 kg) load distributed as follows: 25 lbs (11.4 kg) on head section, 100 lbs (45.4 kg) on back section, 140 lbs (63.6 kg) on seat section and 35 lbs (15.9 kg) on foot section; the table shall be positioned as follows without perceptible binding or jerking, and without settling after the positions are obtained. If patient weight exceeds 300 pounds, contact your AMSCO representative for further direction.

Table Component	Position Starting With Superstructure Horizontal	Range
Top and Superstructure	Raise — Lower	To any point within 27 to 45 inches (686 to 1143mm) above the floor.
	Trendelenburg (head-down)	0 to 20°
	Reverse Trendelenburg (head-up)	0 to 20°
	Tilt to Right	0 to 10°
	Tilt to Left	0 to 10°
Head Section	Raise (from horizontal)	0 to 90°
	Lower (from horizontal)	0 to 90°
Back Section	Raise	0 to 90°
	Lower	0 to 10°
	*Flex	0 to 15°
	*Reflex	0 to 10°
Seat Section	*Flex	0 to 20°
	*Reflex	0 to 15°
Foot Section	Lower (with Seat Section horizontal)	0 to 105°
Kidney Elevator	Raise (from tabletop level)	approx. 4½ inches (114mm)

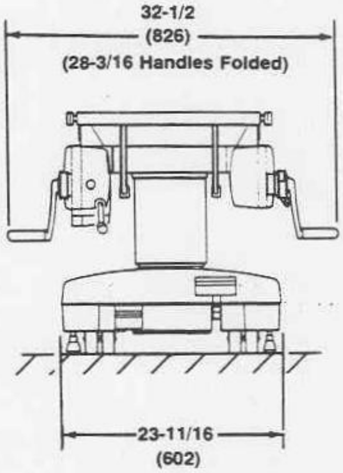
*Flex and Reflex positioning involves simultaneous movement of Back, Seat and Foot sections.


3-1/2
(89)
3-1/2 (89)
20
(508)
22-3/8
(568)
18
(457)
21-5/8
(549)
19-3/4
(502)
16-1/8
(410)
18-1/2
(470)
2-1/4
(57)
5-1/8
(130)
10-1/2
(267)

TOP VIEW


72-1/4
(1835)
Head End
27 Inches
(686mm)
Minimum
45 Inches
(1143mm)
Maximum
Finished
Floor
35-1/4
(895)

SIDE VIEW


32-1/2
(826)
(28-3/16 Handles Folded)
23-11/16
(602)

HEAD-END VIEW

DIMENSIONS ARE INCHES (MILLIMETERS) — DRAWING IS NOT TO SCALE

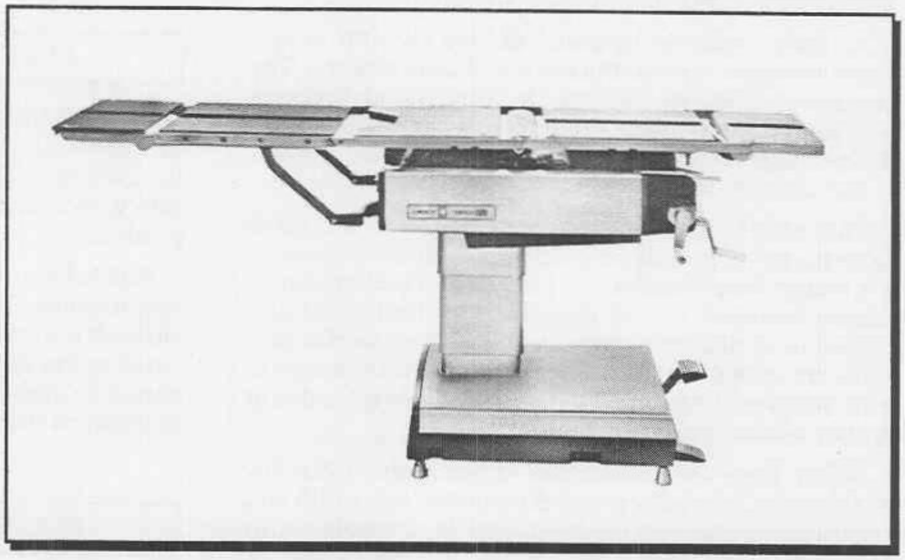
NOTES:

1. Approximate weight — 690 lbs (313 kg).
2. Male connector to ground patient is not furnished by AMSCO.

This print is for guidance when planning space and utility services. Actual installation prints may be obtained from any AMSCO office or representative.

AMSCO
2080 Series
Major Surgical Table

- *2080*
- *2080 IA*



Typical only — some details may vary

APPLICATION

This Table provides flexible articulated posturing of the surgical patient, assuring maximum operative convenience with built-in **Image Amplification** compatibility (on I. A. models only).

DESIGN AND CONSTRUCTION

General. The 2080 manual Table models comply with the Radiation Control for Health and Safety Act of October 18, 1968 and is hydraulically raised and lowered. Hand cranks, geared for easy positioning, provide tabletop articulation. It meets all requirements of Underwriters Laboratories standard UL 544 as certified by ETL Testing Laboratories, Inc.

Base is cast iron with textured enamel finish. The top is enclosed by a welded, stainless steel cover that also forms a shroud for the lower portion of the pedestal. A swivel caster and height-adjustable floor lock at each corner are actuated by a single pedal. Both are electrically conductive, conforming with applicable requirements of NFPA's publication, *Flammable Anesthetics Code.* The base provides comfortable toe space on both sides as well as space to freely insert a flat blade Mayo stand. The base also contains the hydraulic system. An NFPA-approved patient grounding receptacle is provided at foot end of base.

Pedestal includes tabletop lift cylinder and support column with bearing mounted saddle frame. These are fully enclosed by stainless steel, telescoping shrouds. Each shroud is one-piece construction to ensure against foreign matter entering the elevating mechanism.

Superstructure includes bearing mounted gears for positioning and articulating the tabletop. The frame is cast aluminum finished with textured enamel paint. The superstructure is bearing mounted to the elevating mechanism. Indicators show degree of lateral tilt and Trendelenburg. Positioning mechanisms are fully enclosed by stainless steel covers to prevent enmeshment of drapes.

Tabletop. The 20-inch (508-mm) wide tabletop (see page 4) is divided into five hinged sections: head, back, seat, leg and head/foot. Head, back and seat sections are cast aluminum (back and seat sections are covered

THE SELECTIONS BELOW APPLY TO THIS EQUIPMENT

MODEL

☐ 2080

☐ 2080 IA

OPTION

☐ Accessories *(see separate product literature)*

Item ____________________

Location(s) ______________

____

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by stainless steel veneer, while leg and head/foot sections are constructed of radiotranslucent material in imaging areas). Drilled holes are included for the radiographic top. Stainless steel side rails, notched to receive optional accessories, extend the full length. Mounting hardware and a full complement of optional accessories are available (*see separate product literature*).

The leg and back sections are safely supported by two hinged, steel lever arms.

The tabletop is bearing mounted to the superstructure at the seat section. The seat section includes a perineal cutout. The tabletop (with exception of the head and head/foot sections) is positioned by hand cranking. The head section is secured by a manual, spring-loaded, ratchet mechanism. A Velcro® (Velcro Corporation) tape strip on the longitudinal centerline of the table permits instant application and removal of 2-inch thick standard pads or D.A.D. pressure management pads — no other pad-fastening devices are required.

An independently operated kidney elevator is centrally located between the back and seat sections. The elevator is raised and lowered by a crank and dual rack and pinion mechanism, operating in conjunction with the gearing and jointed drive shaft. The kidney elevator is cast aluminum covered by stainless steel veneer.

The head/foot section, attached to leg section, extends table length to permit reversing the patient on the table for Image Amplification. The head/foot section can be raised/lowered, 0 – 90 degrees from horizontal and locked in 15 degree increments. Head/foot section also folds completely under leg section so as not to interfere with standard table positioning. The handle is located at end of section for easy actuation.

X-Ray Tops are constructed of permeable phenolic, are electrically conductive and mount on full width and length of tabletop. The radiographic top complies with the Radiation Control for Health and Safety Act of October 18, 1968. A 14 x 17 inch (356 x 432 mm) radiographic cassette can be inserted from head end or foot end; 12 x 14 inch (305 x 356 mm) radiographic cassette, from side, head end or foot end. (Radiographic cassettes are not furnished by AMSCO.)

OPERATING CONTROLS

Hand cranks and selectors requiring operator attention are all at the head end of the table, easily accessible to the anesthesiologist.

Foot Pedals are easily actuated and clearly identified. They include:

- LOCK — to engage either the casters or locks with the floor.
- RAISE/LOWER — to raise or lower the tabletop.

Tabletop Positioning Controls are mounted at a convenient height on the superstructure — arranged for simple, accurate actuation. After setting the selector for the desired movement, the tabletop is positioned by operating the crank handle. Selections include:

- TRENDELENBURG — to lower or raise the head end of the superstructure from horizontal, to achieve Trendelenburg (head down) and reverse Trendelenburg (head up). Control is on left side of head end.
- BACK — to lower or raise the back section.
- SIDE — to laterally tilt the superstructure to the right or left.
- LEG — to lower or raise the leg section.
- FLEX — to simultaneously position the back and seat sections, so as to achieve an inverted "V" (flex) or "V" (reflex) position.

ACCESSORIES

See separate product literature.

MATERIAL SPECIFICATIONS

General. Materials not definitely specified herein are of the best quality routinely employed for the purpose in the industry. They have been selected to enhance the safety, serviceability and appearance of the finished product.

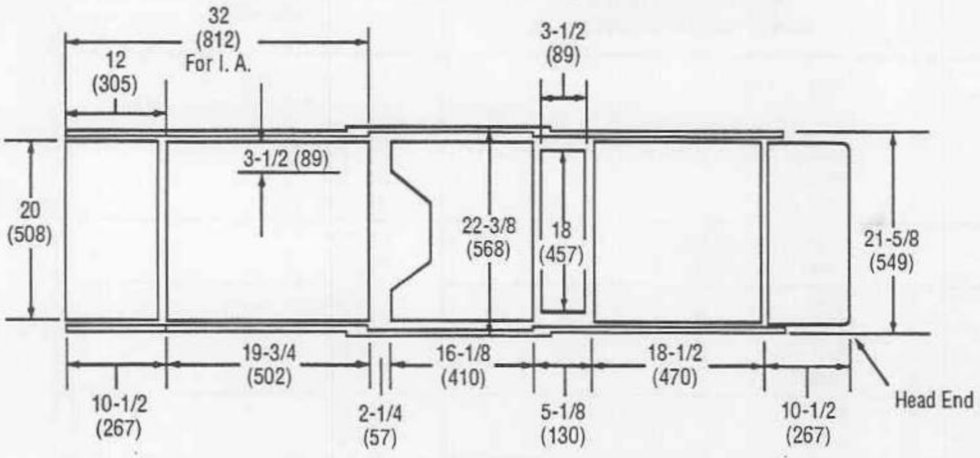
Finish. Exposed stainless steel (conforming with ASTM Specification A 167), aluminum and chromium plated surfaces are polished. Cast iron and carbon steel exterior surfaces are degreased, phosphatized and coated with corrosion-resistant primer followed by two spray coats of textured enamel paint. The finish is then oven baked.

PERFORMANCE CAPABILITIES

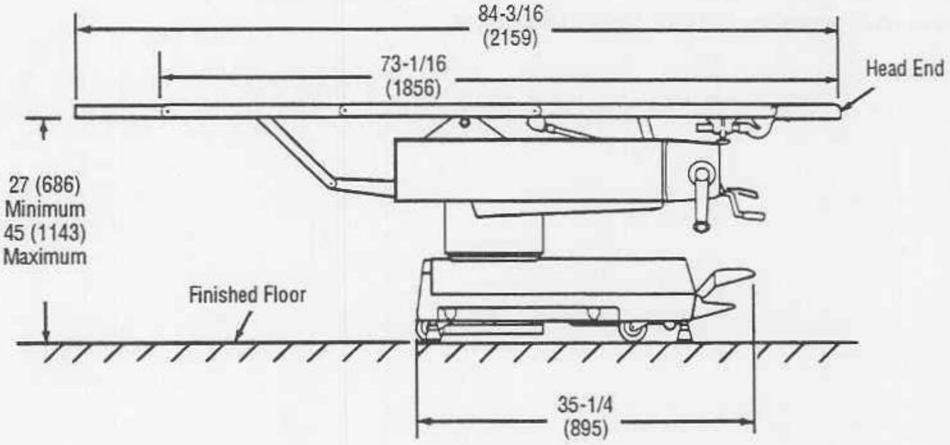
When operated with a 300 lb (136 kg) load distributed as follows: 25 lbs (11.4 kg) on head section, 100 lbs (45.4 kg) on back section, 140 lbs (63.6 kg) on seat section and 35 lbs (15.9 kg) on foot section; the table shall be positioned as follows without perceptible binding or jerking, and without settling after the positions are obtained.

TABLE COMPONENT	POSITION STARTING WITH SUPERSTRUCTURE HORIZONTAL	RANGE
Top and Superstructure	Raise — Lower	To any point within 27 to 45" (686 to 1143 mm) above the floor.
	Trendelenburg (head down)	0 to 20°
	Reverse Tredelenburg (head up)	0 to 20°
	Tilt to Right	0 to 10°
	Tilt to Left	0 to 10°
Head Section	Raise (from horizontal)	0 to 90°
	Lower (from horizontal)	0 to 90°
Back Section	Raise	0 to 90°
	Lower	0 to 10°
	Flex*	0 to 15°
	Reflex*	0 to 10°
Seat Section	Flex*	0 to 20°
	Reflex*	0 to 15°
Leg Section	Lower (with Seat Section horizontal)	0 to 105°
Head/Foot Section	Raise (with Seat Section horizontal)	0 to 90°
	Lower (with Seat Section horizontal)	0 to 180°
Kidney Elevator	Raise (from tabletop level)	Approx. 4-1/2" (114 mm)

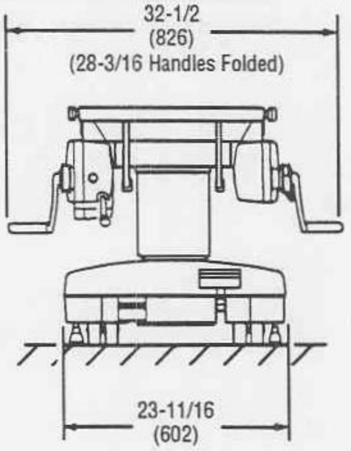
*Flex and Reflex positioning involves simultaneous movement of Back, Seat and Foot sections.


32
(812)
For I. A.
12
(305)
3-1/2
(89)
3-1/2 (89)
20
(508)
22-3/8
(568)
18
(457)
21-5/8
(549)
19-3/4
(502)
16-1/8
(410)
18-1/2
(470)
10-1/2
(267)
2-1/4
(57)
5-1/8
(130)
10-1/2
(267)
Head End

TOP VIEW


84-3/16
(2159)
73-1/16
(1856)
Head End
27 (686)
Minimum
45 (1143)
Maximum
Finished Floor
35-1/4
(895)

SIDE VIEW


32-1/2
(826)
(28-3/16 Handles Folded)
23-11/16
(602)

HEAD END VIEW

DIMENSIONS ARE INCHES (MILLIMETERS) — DRAWING IS NOT TO SCALE

This print is for guidance when planning space and utility services. Actual installation prints may be obtained from any AMSCO office representative.

NOTES

1. Approximate weight — 690 lbs (313 kg).
2. Male connector to ground patient is not furnished by AMSCO.

. . .CHECK LOCAL CODES. . .

AMSCO

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CHAPTER I
OPERATION

WARNING: **TIPPING HAZARD. DO NOT OPERATE THIS TABLE WITHOUT ENGAGING FLOOR LOCKS.**

1. TABLE ELEVATION

a. Raise. With table floor locks engaged, pump the RAISE/LOWER pedal until table reaches desired height. Pedal travel should extend from maximum height to approximately ⅛ inch above the floor when pedal is pumped. When pedal is released, thereby returning to maximum height, the hydraulic circuit is closed by a ball checkvalve to maintain the desired height. If pedal stroke reaches floor during pumping, table top will not elevate.

b. Lower. To lower the table top from any elevation, depress the RAISE/LOWER pedal to the floor and hold in this position until desired height is obtained. Release of this pedal and its return to maximum height will lock the hydraulic lift in position.

2. TRENDELENBURG

Facing table from the head end, turn crank on the left side to obtain the desired amount of trendelenburg and reverse trendelenburg. Clockwise rotation will move table top in the head down direction up to a maximum of 20 degrees. Counterclockwise rotation of this crank will move the table top in the head up direction up to a maximum of 20 degrees. The table top may be positioned in any intermediate position within this 40 degree arc and is locked in place by self-locking gears.

3. HEAD SECTION

The head section has a ratchet-type lock. The release or control handle (located beneath the working surface on the right side of the table) is spring loaded to assure positive locking action. To adjust, pull the release handle away from the head section pivot point. Head section of table can now be positioned up or down through a 90 degree arc. Releasing handle at any position within this 180 degree arc will automatically lock the headrest in position.

4. LATERAL (SIDE) TILT

Shift selector lever (located adjacent to handcrank on right side of table) to SIDE position. Rotation of the handcrank in a clockwise direction will move table top in the right side tilt direction up to a minimum of 10 degrees. Counterclockwise rotation of this handcrank will move table top in the left side tilt direction up to a minimum of 10 degrees. The table top may be positioned in any intermediate position within this 20 degree arc and is locked in place by a power screw arrangement.

5. LEG SECTION

Shift selector lever (located adjacent to handcrank on right side of table) to FOOT position. Rotation of the handcrank in a clockwise direction will elevate the foot section to a maximum of horizontal (when side frame and seat section are horizontal). Counterclockwise rotation of handcrank will move leg section down until the section bumpers come to rest against the superstructure (approximately 105° travel from horizontal).

CAUTION: When lowering leg section more than 45 degrees, make sure table top is near zero degrees side tilt or the leg section arms will strike the sheet metal shrouds covering the elevating mechanism.

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6. FLEX

Shift selector lever (located adjacent to handcrank on right side of table) to FLEX position. Rotation of the handcrank in a clockwise direction will move the table top into the flex or "V" position. Counterclockwise rotation of the handcrank will move the table top into the reflex or "Λ" position.

7. BACK SECTION

Shift selector level (located adjacent to handcrank on right side of table) to BACK position. Rotation of the handcrank in a clockwise direction will elevate the back section. The back section has a maximum travel of 90 degrees up from the horizontal. Counterclockwise rotation of the handcrank will lower the back section until the section bumpers come to rest on top side of superstructure.

8. KIDNEY ELEVATOR (Units Shipped Before 8/74)

The kidney elevator is actuated by means of a ratchet-type mechanism. The operating handle is located on the inside surface of the superstructure housing the trendelenburg gearing (left side of superstructure facing table from head end). To operate the kidney elevator, stroke the handle through an arc of approximately 60 degrees. To reverse the direction of movement, rotate the white plastic knob where the handle is connected to the side frame and stroke handle.

CAUTION: If table top is articulated in any position other than horizontal, observe elevator movement since it can interfere with top sections. It is also good practice to lock handle in the Horizontal position when not in use to prevent damage to base cover during trendelenburg operation.

---

9. KIDNEY ELEVATOR (Units Shipped After 8/74)

The kidney elevator is actuated by means of a handcrank. The handle is on the end surface of the superstructure housing the Trendelenburg gearing (left side of superstructure facing table from head end). To operate the kidney elevator, rotate handcrank clockwise to raise and counterclockwise to lower.

CAUTION: If table top is articulated in any position other than horizontal, observe elevator movement since it can interfere with top sections. Fold handle up to prevent damage during Trendelenburg operation.

---

10. FLOOR LOCKS

Depress the LOCK pedal to the bottom and release slowly. This places table weight on four rubber pads which retard table movement but retains the electrical conductivity. To unlock floor locks, depress the LOCK pedal and allow pedal to return to maximum height or the unlocked position. If floor lock operates with any degree of difficulty or will not immobilize the table, adjust floor locks as described in Chapter IV.

11. HEAD/FOOT SECTION (2080M I.A.)

WARNING: CRUSHING HAZARD. CAUTIOUSLY LOWER LEG SECTION OR POSITION TABLE IN REVERSE TRENDELENBURG WHEN HEAD/FOOT SECTION IS EXTENDED.

The head/foot section has a ratchet-type lock. The release or control handle (located beneath the working surface on the right side of the table) is spring loaded to assure positive locking action. To adjust, pull the release handle away from the leg section. Head/foot section can be raised/lowered, 0-90 degrees from horizontal and lock in 15 degree increments. Section also folds completely under leg section so as not to interfere with standard table positioning.

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CHAPTER II
HYDRAULIC SYSTEM

1. GENERAL DESCRIPTION (Figure 2-1)

Actuating the RAISE/LOWER pedal to within 1/8 inch of the floor draws oil, under pressure, through a strainer to the pump.

When the plunger on the pump is forced back, oil is drawn up into the cavity. When the plunger is pushed forward, it pushes oil out through a ball check valve, into the copper tubing that goes to the lift cylinder. Continued operation of the pump will put oil into the lift cylinder and elevate the table.

With the table in any intermediate position, depressing the RAISE/LOWER pedal all the way to the floor will cause the piston to unseat the ball check and hold it open as long as the pedal is held to the floor. This allows oil to gravitate back from the lift cylinder to the sump.

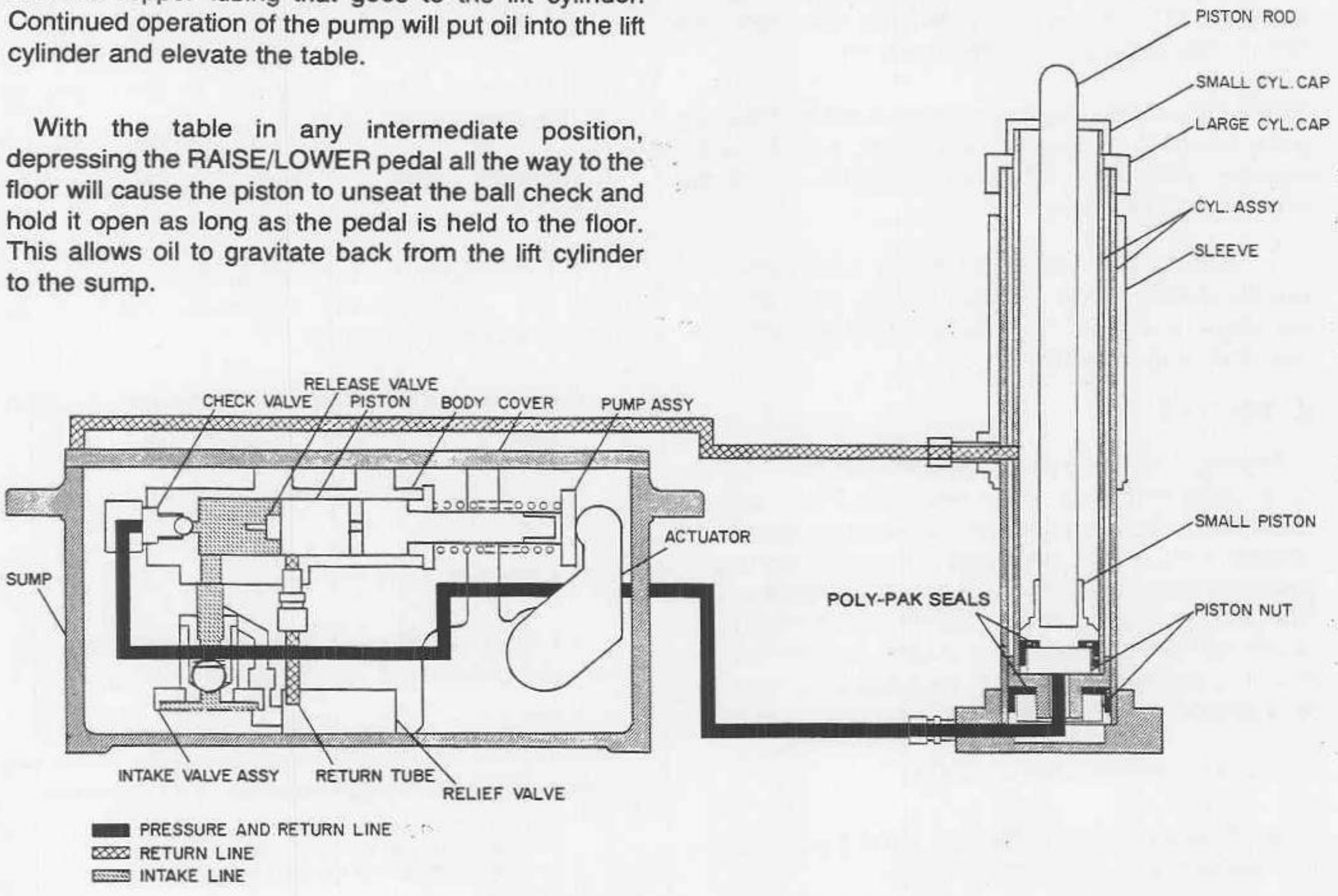
PISTON ROD
SMALL CYL. CAP
LARGE CYL. CAP
CYL. ASSY
SLEEVE
RELEASE VALVE
CHECK VALVE
PISTON
BODY COVER
PUMP ASSY
ACTUATOR
SUMP
SMALL PISTON
POLY-PAK SEALS
PISTON NUT
INTAKE VALVE ASSY
RETURN TUBE
RELIEF VALVE
■ PRESSURE AND RETURN LINE
▨ RETURN LINE
▤ INTAKE LINE

Figure 2-1. HYDRAULIC DIAGRAM.

2. FILLING

Check oil level as described in paragraph 4 of Chapter IV. If oil is required add oil using funnel. Capacity of sump is approximately 2 quarts. Hydraulic Oil (P-150823-020) is a recommended oil (Refer to Paragraph 5). When filled, the sump has a measurable oil level 1-3/4 inches, with top section at maximum height. The measured depth of 1-3/4 inches is more important than having exactly two quarts in the system.

3. BLEEDING

a. Lift the base cover and support as described in paragraph 1a of Chapter IV (see **WARNING** on page 4-1).

b. With the table at its maximum height, slip a thick object such as a hammer handle between elevator 55131 (figure 7-18, sheet 1) and elevator stop 52682. Slip the object in from the front.

NOTE: While bleeding, it is important that the **bleeding port,** which is located on the upper rod of the lift cylinder, does not drift down below the top of the intermediate cylinder.

c. Back out Buttonhead screw and pump the RAISE/LOWER pedal. When oil starts to flow through set screw, the majority of air is out of the system. At this time, tighten screw.

4. TESTING

Testing is required when any hydraulic line is broken or a component has been replaced. Place table in maximum height position and leave in this position for at least 2 hours and preferably 8 hours (or overnight). Measure how much table has dropped during this time. The table should not drop more than 1/16 inch in 2 hours or 3/8 inch in 8 hours or more. A drop of more than this indicates a hydraulic problem, probably a leaking fitting or a defective check valve.

5. REPLACING HYDRAULIC OIL

a. If table contains Solnus #100 hydraulic oil, replace with any one of the following:

- Chevron AW Hydraulic Oil, Grade 32
- Mobil DTE 24 Hydraulic Oil
- Shell Tellus 32 Hydraulic Oil

All three can be purchased locally or order Chevron (P-764316-241) from Service Company.

NOTE: Starting with Serial Number 0406281-XXX, tables shipped from factory will have a tag (see Figure 2-2) attached to the table base. The tag will identify what type of oil was used when the table was built.

CAUTION: Do NOT mix different brands of hydraulic oil.

Use the following procedure to drain and flush tables in preparation of hydraulic oil change.

b. Procedure For Replacing Hydraulic Oil On 2080 And 110 GU Tables:

(1) Drain all oil from table sump, tubing and lift cylinder. Discard oil.

(2) Wipe out sump.

(3) Change oil filter assembly (P-56276-001) or oil filter cartridge (P-50697-091).

(4) Refill hydraulic system using an approved oil.

(5) Operate table through all positions at least once for each mode: electrical, manual, or emergency (as appropriate).

(6) Drain sump, tubing and lift cylinder. Discard oil.

(7) Refill hydraulic system, again using the oil used in step 4.

(8) Operate table through all positions.

(9) Mark tag (Figure 2-2, P-56397-013) with type of oil now being used. Attach tag to table base.

THIS EQUIPMENT WAS ORIGINALLY FILLED WITH

☐ **CHEVRON AW HYDRAULIC OIL GRADE 32**
☐ **MOBIL DTE 24 HYDRAULIC OIL**
☐ **SHELL TELLUS 32 HYDRAULIC OIL**

NO SUBSTITUTIONS ARE TO BE USED UNLESS SPECIFIED IN THE OPERATORS MANUAL

AMSCO PT. NO. **PT. NO. 56397-013**

Figure 2-2. HYDRAULIC OIL TAG.

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CHAPTER III — TROUBLESHOOTING

REFER TO SHEET 2 FOR PRESSURE READINGS

		HYDRAULIC						MECHANICAL						
		LEAKS FITTING	STRAINER	CHECK VALVES	LIFT CYLINDER CUPS/SEALS	AIR BLEED	LOW ON OIL	WEAR PLATES	BEARINGS	ADJUSTMENT	GREASE	LATCH FLOOR LOCK	GEARS	SPRING
MANUAL EMERGENCY PUMP WON'T OPERATE		2	4	3			1							
CASTERS DON'T SWIVEL FREELY									1		2			
NOISY ERRATIC PUMP OPERATION			3			2	1							
DRIVE CRANK CLUTCH DISENGAGES TOO SOON										A8				
HEAD UP HEAD DOWN	INADEQUATE MOVE TO FULL 20°									A3				
	TOO SLOW MOVEMENT IN POSITIONS						1			A3				
	ERRATIC JERKY MOVEMENT					1					2		3	
	EXCESSIVE TOP SECTION LOOSENESS									A3 A5				
SIDE TILT	TOO SLOW MOVEMENT					2	1			A7	3			
	WON'T MOVE										2		1	
	EXCESSIVE LOOSENESS LATERALLY							1		A7				
LEG SECTION	EXCESSIVE LOOSENESS									A1 A4				
	SLOW MOVEMENT					1					2		3	
FLEX REFLEX	WON'T MOVE									A1 A2				
	TOO SLOW MOVEMENT					1				A1 A2				
RAISE LOWER	SLOW MOVEMENT		2			1				A5				
	WON'T HOLD HEIGHT			1	2									
	CHATTER, RAISING OR LOWERING				1	2				A5				
	SUDDEN DROP									A9				
BACK SECTION	WON'T MOVE FROM HORIZONTAL TO UP									A4				
	WON'T MOVE FROM UP TO HORIZONTAL									A4				
	EXCESSIVE LOOSENESS									A1				
	SLOW MOVEMENT		2			1			3	A1	4			
FLOOR LOCKS	WON'T LOCK									A6		1		2
	PEDAL DOESN'T RETURN									A6				1
	PEDAL HANGS UP									A6		1		
	PEDAL RETURNS — FEET DON'T RETRACT								3	A10	1			2

NUMBERS: ORDER OF SIGNIFICANCE FOR CHECKING CAUSE OF FAILURE

REFERENCE MATERIAL (LETTER AND NUMERAL)

SEE RELATED ADJUSTMENT PROCEDURE

		MANUAL REFERENCE (PAGE)
A1	BACK OR LEG SECTION WORM AND GEAR	4-5
A2	SEAT SECTION WORM AND SECTOR	4-6
A3	TRENDELENBURG WORM AND SECTOR	4-6
A4	DRIVE HEADS END PLAY	4-5
A5	LIFT CARRIAGE	4-7
A6	FLOOR LOCKS	4-1
A7	SIDE TILT	4-8
A8	SELECTOR SWITCH ASSEMBLY	4-9
A9	REPLACE LIFT CYLINDER	5-2 4-9
A10	PEDAL LEVELING	4-3

	MANUAL REFERENCE
LUBRICATION PROCEDURE	CHAP II
HYDRAULIC DIAGRAM	FIG. 2-1

GENERAL LOCATIONS OF COMPONENTS

GENERAL LOCATION	FIGURE
BASE	7-18
TOP-DRIVE SIDE ENCLOSED IN H-FRAME	7-2 SH3
TOP TREND. SIDE ENCLOSED IN H-FRAME	7-2 SH2
FLOOR LOCKS	7-22
LIFT CYLINDER	7-23

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CHAPTER IV
MAINTENANCE INSPECTION AND ADJUSTMENTS

WARNING: BE SURE TABLE TOP IS PROPERLY SUPPORTED BEFORE PERFORMING ANY MAINTENANCE REQUIRING THE TABLE TOP TO BE MAINTAINED IN THE "RAISED" POSITION.

1. SUPPORTING TABLE TOP

a. With Base Cover Raised (Figure 4-1)

(1) Remove the four socket-head cap screws 52718 (figure 7-18, sheet 2) that secure base cover 99324 to the base casting.

(2) Raise the table top to its maximum height.

(3) Lift and support base cover 99324 and shrouds 99326 and 99327 by blocking from base or tying to table frame.

(4) Support table top by inserting a spacer, ten-inch Crescent wrench or equivalent between the top of 2½-inch-square steel post and underside of the elevator carriage end plates (roller side).

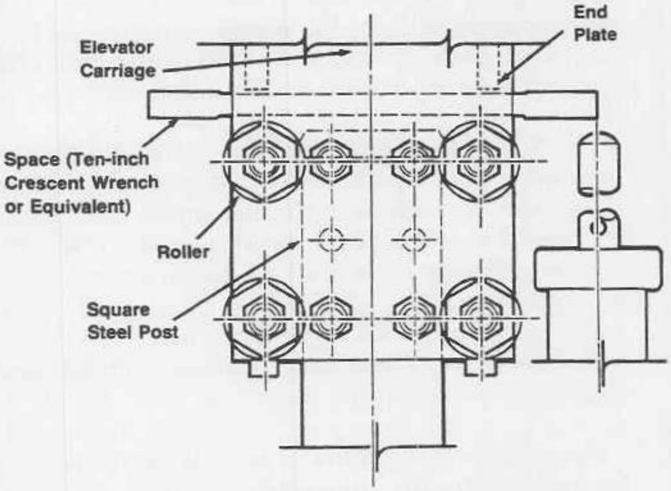

Figure 4-1. SUPPORTING TABLE TOP.

(5) Depress RAISE/LOWER pedal and allow elevator carriage to settle on top of spacer. Release and again depress RAISE/LOWER pedal to be sure the table top is securely supported (cannot lower).

(6) Be sure spacer is **not** bending. If it is, remove and replace it with a stronger item.

b. When Base Cover Is Not Raised

(1) Raise the table top to maximum height.

(2) Place a support (saw horse or another table) under the table top. Be sure it is so positioned that it will not damage any of the table components.

(3) Depress RAISE/LOWER pedal to gently lower the table top onto the support.

(4) Be sure table is stable.

2. FLOOR LOCKS

NOTE: Improper adjustment is the main reason for difficult floor lock operation. The force required to operate the floor locks should not change appreciably, whether or not the table is occupied. When the floor locks are properly adjusted, the casters **need not be raised off the floor** (i.e., they **should not** swing freely with the table in the locked position). Each floor lock should be *equally* engaged and, therefore adjusted individually. Some other reasons for difficult floor lock operation are: binding of pedal linkage, insufficient clearance between pedal and floor, pedal sticking in the up (unlocked) position, or pedal failing to return to the maximum up position.

Be sure you read and understand the entire procedure before attempting to make any adjustments (refer to figure 7-22).

Operate the LOCK pedal several times to evaluate floor lock operation, and if necessary, proceed to the applicable problem-correction procedure.

a. Floor Lock Improperly Adjusted

(1) Place the LOCK pedal 133687 in its up (unlocked) position. Adjust all four feet 150199 clockwise as far as possible.

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NOTE: The feet should not turn freely by hand; the adjustment should require a wrench. Feet that turn freely will not hold adjustment; therefore, the pin foot assembly 150202 should be replaced.

(2) Place LOCK pedal in its down (locked) position. Adjust all four feet counterclockwise until they are snug (slight resistance is noticed) on the floor.

(3) Place LOCK pedal in its up position. Adjust all four feet counterclockwise ½ turn.

(4) Operate the LOCK pedal through several cycles. Operation should be smooth and positive; the table base should rise evenly as the floor lock is actuated (not one side before the other). With the lock engaged, the table should not rock or move when normal forces are applied. You may find that a further ¼-turn of the feet in either direction will "fine tune" the operation.

b. Binding of Pedal Linkage (see **WARNING** on page 4-1). If binding is evident during pedal operation, place LOCK pedal in its unlocked position and check the following.

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Press down on top of floor locks rods 41530 and then release, allowing the lever arms to spring back. If this action is not free, proceed as follows:

(a) Be sure the reamed holes in the base casting for the floor lock feet are properly lubricated.

(b) Be sure pivot holes in lever arms are free to rotate on the shoulder screws 82481. (**NOTE:** Excessive plating in a hole could result in a tight fit and subsequent binding.)

(c) Check for interference between any two parts which would require an increased effort to operate (e.g., ends of lever arms riding on the base casting during operation).

(3) Depress LOCK pedal slightly (but not enough to lock) and then release. Repeat this several times. Be sure the pedal does not rub on the base casting, drip pan or other surfaces. The pedal should spring back rapidly when released; if it does not, proceed as follows:

(a) With the table top at its maximum height, lean the table against the wall and block the base to prevent it from moving.

(b) Remove the two screws 31838 in each of the three bearing blocks 78203; then take out the floor lock cross shaft 55084. If necessary, remove a caster 36584 by unfastening the nut 13397 on the top of the base casting.

(c) Measure the free length of the pedal return spring 80117. Replace spring if it is not 2-1/4 ±1/16-inches long.

(d) Check the hole in the underside of the base casting from which the pedal return spring was removed. Be sure the chamber (1/8 inch by 45 degrees) is sufficient to prevent the spring from catching.

(e) Replace the cross shaft, pedal return spring and bearing blocks removed in step b. Operate the cross shaft several times to be sure there is no binding. If necessary, loosen the screws and reposition the bearing blocks. (**NOTE:** The shaft will bind if the bearing blocks are not in line.)

(f) Check the adjustment of the pedal return spring set screw 80196 on the top of the base casting, accessible through the hole in the motor support. The screw should be adjusted to extend approximately 7/16 inch above the base casting. Turn the screw clockwise to increase spring tension and aid pedal return.

(g) Inspect the two cams 77731 on the ends of the cross shaft. Replace them if the cam surfaces are not smooth. Be sure the cams are parallel and contact the lever arm rollers 45272 simultaneously. The roller can be repositioned by moving the supports for the locking arms.

c. Insufficient Clearance Between Pedal and Floor (see **WARNING** on page 4-1)

Proceed as follows if the pedal is striking or coming too close to the floor during floor lock operation.

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Loosen the four screws 31838 which secure the bearing blocks 77521 supporting the latch casting 55088.

(3) Place an equal number of shims under both bearing blocks at each screw.

(4) Operate the floor locks and observe the latch operation. Be sure the pin 79878 in the pedal arm engages the latch during locking and that the latch swings clear of the pin during unlocking. If necessary, increase the height of the latch spring 47777 on the base stud 47939 by repositioning the two nuts 3097. The distance between the bottom nut and the base casting should be approximately 1-5/16 inches. The floor locks are designed to operate on a relatively level floor. If table is used in a room with a slope to a floor drain, further adjustments may be necessary.

d. Pedal Sticks In Up Position (see **WARNING** on page 4-1)

Proceed as follows if the pedal will not depress.

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Be sure the pin 79878 is centered in the pedal arm and that it is locked in place with the set screw 10585.

(3) Be sure latch 55088 operates properly.

(4) Refer to step 4 in paragraph 2c of this chapter and check the adjustment of the latch spring.

e. Pedal Does Not Return To Maximum Up Position (see **WARNING** on page 4-1)

If the pedal does not return to the maximum up position, the pedal arm pin will not properly engage the latch during the next lock cycle. Therefore, proceed as follows:

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Be sure the pedal leveling screws 79593 (figure 7-18) are properly adjusted, and the LOCK pedal screw does not prevent it from returning to the maximum up position.

(3) Refer to step 4 in paragraph 2c of this chapter and check the latch operation.

(4) Refer to step 3 in paragraph 2b of this chapter and check the condition and adjustment of the pedal return spring.

3. PUMP PEDAL ADJUSTMENT

Pump the RAISE/LOWER pedal to raise table to extreme height. Depress the RAISE/LOWER pedal to approximately ⅛ inch from the floor and observe that table descends at this point. If it doesn't, adjust pump pedal as described below (see **WARNING** on page 4-1):

a. Lift and support the base cover as described in paragraph 1a of this chapter.

NOTE: Set screw 10585 (figure 7-18, sheet 1) and nylon plug 22436 secure adjusting screw 23418.

b. Loosen set screw 10585 (figure 7-18, sheet 1) on side of pedal.

c. Turn adjusting screw 23418 (figure 7-18, sheet 1) clockwise until table top descends when RAISE/LOWER pedal is approximately ⅛ inch from floor.

d. After adjustment is complete, tighten set screw 10585.

e. Replace cover.

4. HYDRAULIC SYSTEM

a. Oil Level (See WARNING on page 4-1)

(1) Remove base cover and support as outlined in paragraph 1a of this chapter. Table top must be at maximum height.

(2) Remove pipe plug 20580 (figure 7-19) which is located on sump cover plate 77507 (figure 7-19).

(3) Insert a clean, dry object about the size of a pencil through the hole now vacated by the set screw until object touches bottom of the sump.

(4) Withdraw object and measure indicated height of the oil. Depth of oil should be 1¾ inches. If oil level is below this height, add the proper oil. (See **NOTE** below.) Do not overfill.

NOTE: This table uses Hydraulic Oil (P-764316-241). Substitute oil should not be used. **Refer to Paragraph 5, Chapter II.**

(5) Replace plug and base covers.

b. Strainer. A dirty or plugged strainer can result in erratic, sluggish or noisy table operation. To clean the strainer, proceed as follows:

(1) Pump the RAISE/LOWER pedal until table reaches maximum height.

See **WARNING** on page 4-1.

(2) Lift the base cover and support as described in paragraph 1a of this chapter.

(3) With the table at its maximum height, slip a strong metal object (such as an 8- or 10-inch Crescent wrench) between table support 133636 (figure 7-18, sheet 1) and elevator stop 52682. Slip the object in from the front and above top set of rollers.

(4) Depress the RAISE/LOWER pedal to the floor and hold in this position until table comes to rest on the wrench. Visually check supporting arrangement. If any bending is present in supporting tool, do not use but obtain a heavier cross sectioned tool.

(5) Remove socket head screws 37891 (figure 7-19) and lockwashers 19685 securing cover 77507 and remove cover and gasket 77506 from sump 99310.

(6) Reach down inside sump and disconnect hydraulic line 79475 (figure 7-20) from fitting 45565 (figure 7-19).

(7) Remove four socket head screws 13411 (figure 7-19) and lift pump assembly 55087 from sump 99310.

(8) Unscrew valve assembly 22898 (figure 7-20) from nipple 27422 and back flush to clean the strainer which is part of the valve assembly.

(9) After cleaning or replacing strainer, reassemble pump in the sump and lower base cover and table. If necessary, replace gasket 77506 (figure 7-19) during reassembly. If hydraulic leakage is observed while lowering table, refer to paragraph 4c of this chapter.

c. Hydraulic Leakage.

There should be no signs of oil leaking from any part of the base. Leakage, which could result in the table top lowering, can be caused by loose fitting on copper line running from pump to lift cylinder, defective seal on the lift cylinder or defective check valve in the pump assembly. If leakage is still observed after checking fittings, remove pump assembly as described in paragraph 4b of this chapter and replace valve in the pump. Access to the check valve may be made by following the disassembly sequence illustrated in figure 7-20, starting at fitting 42510.

When checking the lift cylinder for an oil leak that causes the table top to lower, do not overlook the possibility that the leak may be from the cylinder bleeder port. This port is in the small assembly piston rod and is revealed only when the lift cylinder is fully extended. If oil is leaking past the O-ring seal, it will run down the piston rod inside the upper cylinder cap 80932 with all indications of a leaking seal. Oil leakage at the bleeder port is mainly caused by an overtightened screw which tends to extrude or distort the O-ring seal. This screw should be tightened only enough to seal the bleeder port. Check the bleeder port for oil leakage as follows:

(1) Elevate the table top to maximum height.

(2) Wipe the piston rod dry in the area of the bleeder port.

(3) Wait five minutes, then rub the piston rod below the bleeder port with your finger to see if bleeder port is leaking oil.

(4) If oil is leaking (leak rate of 1/4" per 8 hr. or 1/16" per 2 hr.), replace O-ring.

Tables Shipped Before January, 1976 — If oil leaks from lift cylinder and runs down shrouds onto floor, add splash cup (24265-091) to lift assembly. Slide splash cup assembly over small piston rod at top of small cylinder cap (see Figure 4-2).

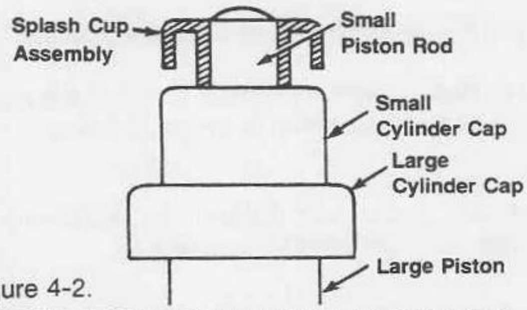

Figure 4-2.
INSTALLATION OF SPLASH CUP ASSEMBLY.

5. TABLE ELEVATION

Pump the RAISE/LOWER pedal to raise the table to its maximum height. The table should rise smoothly and quietly. Depress the RAISE/LOWER pedal to floor. Table should lower smoothly and quietly to the lowest position.

6. TABLE TOP POSITIONING

By correctly manipulating the positioning controls (described in Chapter I, Operation) it should be possible to adjust the table top to any position and articulation within its specified limits. The positioning of the shift selector level should be easy but positive tension adjustment can be made by referring to paragraph 10

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of this chapter. The action of the positioning mechanisms should be positive, quiet, and smooth. If table top positioning adjustments are required, proceed as follows:

NOTE: The back section(55105)(figure 7-2) and leg section (55104) both have a lever arm assembly (55114, groups 1 and 2) which requires adjustment. The procedure described below is applicable to both back and leg section.

a. Drive Head Adjustment. The drive head assemblies of the leg section, seat section, and back section may require adjustment to remove all possible end play of related parts while maintaining free movement of gear involved. The worm wheel 16108 must be backed off from the worm gear 16109 to attain maximum clearance at the gear for the checking of end play. This is accomplished by turning the eccentric bushings 16197.

NOTE: Check each section adjustment with distributed weight of approximately 300 pounds on a horizontal table top. Correct weight distribution is 25 lbs for head section, 100 lbs for back section, 140 lbs for seat section and 35 lbs for leg section.

(1) Leg Section

(a) Loosen cap screw 16425 (figure 7-9D) as required to allow turning of adjusting nut 16184 in leg section.

(b) Back off adjusting nut 16184 (figure 7-9D) so that bearing 16209 is tight and not capable of hand rotation while positioning leg section from horizontal to down position, whereas thrust washer 16214 is free to rotate by hand. Repositioning leg section from down to horizontal will reverse this condition, i.e., thrust washer 16214 will be tight and bearing 16209 is free to rotate by hand.

(c) After adjustment is complete, tighten cap screw 16425 to lock adjusting nut 16184.

(2) Seat Section

(a) Loosen cap screw 16425 (figure 7-9C) as required to allow turning of adjusting nut 16184 in seat section.

(b) Back off adjusting nut 16184 (figure 7-9C) so that bearing 16249 is tight and not capable of hand rotation while positioning seat section from horizontal to flex position, whereas thrust washer 16214 is free to rotate by hand. Repositioning seat section from flex to horizontal will reverse this condition, i. e., thrust washer 16214 will be tight and bearing 16249 is free to rotate by hand.

(c) After adjustment is complete, tighten cap screw 16425 to lock adjusting nut 16184.

(3) Back Section

(a) Loosen cap screw 16425 (figure 7-9B) as required to allow turning of adjusting nut 16115 in back section.

(b) Back off adjusting nut 16115 (figure 7-9B) so that thrust washer 16201 is tight and not capable of hand rotation while positioning back section from horizontal to back up position, whereas bearing 16204 is free to rotate by hand. Repositioning back section from back up to horizontal will reverse this condition, i.e., bearing 16204 will be tight and thrust washer 16201 is free to rotate by hand.

(c) After adjustment is complete, tighten cap screw 16425 to lock adjusting nut 16115.

b. Back or Leg Section Adjustment. The back and leg section both have a worm and gear which may require adjustment. If adjustment is required, proceed as follows:

(1) Loosen two large nuts 16212 on lever arm assembly 55114-001 (back adjustment) or 55114-002 (leg adjustment). (See figure 7-2, sheet 1.)

(2) Tighten stop nut 80930 (figure 7-2, sheet 1) on the trendelenburg side of table top. Thrust washer 16201 (figure 7-7 and 7-8) must be free for finger rotation.

(3) Rotate eccentrics 16197 (figure 7-2, sheet 1) on both sides of table top until contact is made between worm and gear 16247. Eccentrics should be adjusted to same relative position.

(4) Rotate shaft 76253 (figure 7-2, sheet 1) in each direction a few times.

(5) Rotate eccentrics 16197 (figure 7-2, sheet 1) on both sides of table top an equal amount to obtain minimum clearance between worm and gear.

(6) Turn eccentric 16197 on the drive side counterclockwise slightly (approximately ⅛ turn) until worm and gear are free moving by hand rotation.

(7) Lock the drive side eccentric in place with large nut 16212 (figure 7-2, sheet 1).

(8) Position eccentric 16197 on the trendelenburg side to same relative position as the eccentric on drive side.

(9) Lock trendelenburg side eccentric in place with large nut 16212 (figure 7-2, sheet 1). Free movement of worm and gear must be possible at this point.

c. **Seat Section Adjustment.** The seat section has a worm and sector which may require adjustment. If adjustment is required, proceed as follows:

(1) Remove plug buttons 26577 (figure 7-2, sheet 1) by prying free.

(2) Loosen cap screws 43240 (figure 7-2, sheet 1) on both sides of table top.

(3) Centralize sector on worm 16290 (figure 7-4) by turning eccentric 16235 (figure 7-2, sheet 1) on drive side clockwise while, at the same time, moving the seat section laterally back and forth.

(4) Rotate drive side eccentric 16235 to obtain minimum clearance between worm and sector. Force eccentric snugly against section support and secure cap screw 43240 (figure 7-2, sheet 1).

(5) Rotate trendelenburg side eccentric 16235 to the same relative position as the drive side eccentric. Force eccentric snugly against section support and secure cap screw 43240.

NOTE: Free movement of worm and sector 16290 (figure 7-4) should be possible at this point. Readjust slightly if necessary to achieve free movement.

(6) Replace plug buttons 26577 (figure 7-2, sheet 1).

d. **Trendelenburg Adjustment.** The trendelenburg section has a worm and sector which may require adjustment. End play and stop limit adjustments may also be required on the trendelenburg section. If adjustment is required, proceed as follows:

(1) Worm and Sector Adjustment.

(a) Back off nut 24987 (figure 7-2, sheet 3 or 4) which secures swivel head screw 80193.

(b) Loosen swivel head screw 80193 (figure 7-2, sheet 3 or 4).

(c) Loosen cap screws 80222 (figure 7-2, sheet 3 or 4).

(d) Loosen nut 3099 (figure 7-2, sheet 3 or 4) and cap screw 5895.

(e) Tighten screw 5895 to obtain proper mesh of drive gears 23892, (figure 7-14A) and mating gears; lock in place with nut 3099.

(f) Align worm vertically into sector of shaft and bearing assembly 133676 (figure 7-2, sheet 3 or 4) using swivel head screw 80193 to achieve minimum clearance but free movement.

(g) Tighten three cap screws 80222 to secure shaft and bearing assembly 133676 to side frame.

(2) End Play Adjustment. (Refer to figure 7-14 or 7-14A.)

(a) Loosen set screw 4772 in nut 16189 (figure 7-14 or 7-14A).

(b) Tighten adjusting nut 16189 until worm 77639 cannot be rotated by hand.

(c) Back off adjusting nut slowly until rotation of worm is possible.

(d) Lock adjusting nut 16189 with set screw 4772.

(3) Stop Limits Adjustment

(a) Position table top to 20° trendelenburg.

(b) Position screw head 4643 (figure 7-2, sheet 3 or 4) against sector 55123 and lock with nut 33971.

(c) Position table top to 20° reverse trendelenburg.

(d) Repeat step (3-b) above for opposite side of sector.

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7. LIFT CARRIAGE ADJUSTMENT

a. Cam and Roller Adjustment. The elevation guide assembly on table support assembly 133636 (figure 7-18, sheet 1) has eight bearings 46572 (figure 7-21) that regulate the amount of table top movement which can be measured at the head or foot end of the table. If adjustments are required to reduce the amount of "play" or movement, proceed as follows (see **WARNING** on page 4-1):

(1) Lift the base cover and support as described in paragraph 1 of this chapter.

NOTE: Always adjust the eccentrics on one side of the square pedestal only, as this greatly simplifies the adjustment. However, check the four eccentrics on the opposite side to make sure that they are all set in the same relative position and turned in by the same amount.

NOTE: Eccentrics 46478 (figure 7-21) have a locating mark on the low side of the eccentric. When adjusting eccentrics, it is important that the locating mark on each eccentric be in the same relative position.

(2) Back off on hex nuts 78314 (figure 7-21) which secure set screws 80116.

(3) Loosen set screws 80116 (figure 7-21) as required to allow bearing slides 77528 (figure 7-18, sheet 1) to hang free. The slides will not be tightened until after eccentric adjustment is complete.

(4) Loosen four small set screws 43223 (figure 7-21) that lock eccentrics 46478.

(5) Back off on four nuts 78314 (figure 7-21) that seat against the eccentric faces on the side you want to adjust.

(6) Set bearing pressure against column by rotating eccentrics 46478, two in line at the same time, for required adjustment. In the majority of cases, this adjustment will be very small. Adjust the top two eccentrics first, then repeat for the bottom two eccentrics. The locating mark on all four eccentrics should be in the same relative position.

(7) Check bearing adjustment by sliding the support assembly up and down the entire length of the column. Make sure that all eight bearings make contact with the column through entire length of column. Readjust eccentrics if necessary.

CAUTION: Nuts 78314 should be tightened only with slight wrench pressure. Excessive tightening will fracture eccentric at flange.

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(8) After adjustment is complete, tighten set screws 43223 and then lock eccentrics with nuts 78314. Make sure eccentric setting is not disturbed.

b. Slide Bearing Adjustment. The elevation guide assembly on table support assembly 133636 (figure 7-18, sheet 1) has two bronze slide bearings 77528 (figure 7-18, sheet 1) that regulate the table top movement from side to side. If adjustments are required to reduce the amount of "play" or movement, proceed as follows:

(1) Support the table top so that slide bearings 77528 are approximately one-half way up the column.

(2) Centralize the carriage assembly laterally about the column by adjusting eight set screws on the sides of the carriage.

NOTE: Adjust set screws 80116 (figure 7-21) on both sides in equal amounts when bringing bearing faces against column to insure parallel adjustment.

(3) Tighten set screws 80116 (figure 7-21) against slide bearings 77528 (figure 7-18, sheet 1) so as to form a seat in the bearing surface, then back off on the screws slightly.

(4) Adjust set screws 80116 so that the slide bearings are snug against the square column, eliminating all possible side movement of table top but still allowing free movement of carriage along the full length of the column.

(5) Lock set screws 80116 in place with nuts 78314 (figure 7-21).

(6) To check adjustment of the slide bearings, try to rock the table top from side to side. If necessary, readjust.

8. DRIVE CRANK CLUTCH ADJUSTMENT

Once every three months the drive-crank clutch mechanism should be operated in all four of its engaged positions, lubricated, checked for maximum operating force and then if necessary, adjusted (see procedure below). This slot-type clutch mechanism is provided to protect the drive train assembly from excessive torque. When engaged in any of its positions (two clockwise, 180° apart and two counterclockwise, also 180° apart), the mechanism should disengage if a force of 36 to 44 pounds is applied to the drive-crank handle.

NOTE: The following procedure requires Spring Scale, 0 to 50 pound range, P-757290-091 (available from Regional Office); Special Wrench A-753675-045 and *Lubriplate®* No. 630AA (Fiske Brothers Refining Co.) P-751454-091 for 1¾-oz tube or P-754811-091 for 5-lb can.

a. Move crank handle to disengage clutch. Apply a thin coat of *Lubriplate* to the tapered clutch faces between the handle 92016-001 and the shift lever 55093 (figure 7-2, sheet 2).

b. Place the table top in the horizontal position. Be sure it is level and then lower the leg section until the rubber bumpers are against the bottom edge of the superstructure end cap. (This provides a fixed stop without putting excessive stress on other table components.)

c. Slide out the white plastic handle and attach the spring scale to the metal portion of the crank handle.

d. Keeping the spring scale perpendicular (90°) to the handle, pull on scale to rotate crank counterclockwise until clutch disengages. Note the scale reading — it should be between 36 and 44 pounds.

IMPORTANT: The crank will rotate to some degree prior to disengaging the clutch; however the applied force on the scale must at all times be 90° with respect to the drive crank. Any deviation will result in higher readings and a low clutch setting. Never apply more than a 44-pound force; adjust the clutch if necessary (Step h).

e. After the clutch disengages, rotate it 180° counterclockwise to re-engage it; repeat Step d.

f. If the force required in Steps d and e is not between 36 and 44 pounds, proceed to Step h and adjust the clutch.

g. Raise the leg section and place the table top in the reflex (V) position so that its rubber bumpers are resting on the superstructure. Repeat Steps d and e; however this time rotate the handle clockwise. Proceed to Step h if the readings are not between 36 and 44 pounds.

h. If force required to disengage clutch is not between 36 and 44 pounds, adjust clutch as follows.

(1) Remove plug button 25890 from handle of drive crank assembly 92016-001.

(2) Bend tab on lockwasher 81129 free of locknut 81129. Using the special wrench, turn the locknut clockwise to increase, counterclockwise to decrease tension. (The proper setting is for the clutch to disengage from all four positions at 36-44 pounds of force.)

(3) Align slot on locknut with washer tab and bend tab into it. (Nut should not have to be rotated more than 15° to align slot with tap. This will not change the clutch setting.)

(4) Replace the plug button and retest all positions starting with Step b.

9. SIDE TILT ADJUSTMENT

a. End Play Adjustment. Maximum allowable movement of table top at side rail edge is 1/16 inch with top in horizontal position. If adjustment is required, proceed as follows:

(1) Position table top to side, tilt left side (from head end) of table down and in trendelenburg to expose adjusting nuts 75819 (figure 7-10). Do not position in maximum side tilt but obtain maximum and then turn handle one turn back toward horizontal.

NOTE: Set screws 10583 (figure 7-10) and nylon plugs 80203 secure adjusting nuts 75819.

(2) Loosen two set screws 10583 (figure 7-10) and move two adjusting nuts 75819 away from each other.

(3) Turn the front adjusting nut 75819 against thrust bearings to eliminate all end play. When making this adjustment move table top from side to side. This will help remove excessive movement.

(4) Secure the rear adjusting nut 75819 against the front adjusting nut and lock by tightening set screws 10583.

b. Nut, Power Screw Lateral Play. The following adjustment should remove all lateral play yet permit free rotation of nut on the old style power screw. (New style has no adjustment).

(1) To reduce excessive movement of power screw 92945 in nut 92946, tighten two screws 150675 against plate 83250 until screw bottoms, causing the power screw to drag or bind. Back screws out in equal amounts until spring 80107 produces a tension on the plate and reduces excessive movement due to thread clearance.

(2) Tighten button head screws 80213 (figure 7-1) to secure end plates 80111 on one side of the table support assembly.

(3) Tighten end plate (using Button head screws 80213) on other side of table support assembly until power screw nut 92945 begins to drag, then back out all four screws, ¼ turn.

c. Yoke and Saddle Clearance Adjustment. Tighten hex nut 80115 (figure 7-1) until side tilt movement becomes difficult. Back off ¼ turn on nuts.

10. SELECTOR HANDLE LOCATING ADJUSTMENT

Turn set screw 9655 (figure 7-2, sheet 2) clockwise to increase tension or counterclockwise to decrease tension. This adjustment may be made without removing side cover.

11. FRICTION DEVICE ON LIFT CYLINDER-ADJUSTMENT (Units Shipped before 12/72)

This unit controls the staging. of the elevating cylinders as the table moves through its "Raise-Lower" operating range. Being a friction device, it requires readjustment from time to time and should be checked once every three months (see **WARNING** on page 4-1).

NOTE: The following procedure requires Test Fixture P-753909-091 and Spring Scale, 0 to 50 pound range, P-757290-091 (both available from Regional Office).

a. Lift and support the base cover as described in paragraph 1a of this chapter.

b. Depress the "Lower" pedal and place a weight on it to prevent it from rising. Manually compress the lift cylinder 133634-002, 135940-002 or 136375-001 (figure 7-18) to its minimum height.

c. Remove lift cylinder from base assembly by removing four screws 13796 and disconnecting fitting 52737 (figure 7-23) from cylinder base and fitting 7030 from collector can 55369-002.

d. Assemble test fixture to top of 1'' diameter piston rod on lift cylinder. Connect spring scale to test fixture.

e. With lift cylinder at minimum height, gradually pull up on spring scale until small piston breaks free; note the scale reading. (This piston should break free at less than 15 pounds; if it won't, cylinder must be replaced.)

f. With the small piston fully extended, continue pulling up on the spring scale until the larger cylinder breaks free; note the scale reading.

g. The friction device split ring 81142-001 must be adjusted so that the larger cylinder (Step f) will break free at a force 8 to 10 pounds higher than that for the smaller cylinder (Step e). If necessary to adjust the friction device, turn the two screws 81222 clockwise to increase friction, counterclockwise to decrease friction.

h. Repeat Steps e and f three times after the proper friction setting is obtained. If the same differential is not present during each check, replace the lift cylinder and again repeat Steps e and f three times to confirm that break points are within the limits.

i. Remove the spring scale and test fixture. Replace cylinder in table base. Pressurize cylinder and check for leaks at fittings.

j. Remove the weight from the "Lower" pedal. Raise the table top to its maximum height and remove the spacer (wrench). Lower and secure the base cover.

k. Raise the table top to its maximum height. Measure the exact distance from the floor. After one hour, again measure the table height. If it has decreased more than 1/16'', check for leaks; correct and retest, as necessary.

12. KIDNEY ELEVATOR HANDLE (Units Shipped Before 8/74)

If Kidney elevator will not elevate without weight on the elevator, back out set screw 77561 (figure 7-2, sheet 3) one quarter turn. Bridge must operate with or without weights.

13. LATERAL MOVEMENT STOP PIN ADJUSTMENT

a. Place table top in level position.

b. Insert supporter pin 81596 (figure 7-13) through side frame and into saddle 133645. Pin should project beyond saddle, towards the power screw approximately 1-1/4''.

c. Add spacer 81597 and nut 16229 to the pin. Do not tighten nut.

d. Place a 1/16'' thick shim between the button-head screw 81591 and pin 81596. Adjust pin to contact shim against screw head.

CAUTION: Do not drive pin against the shim with any impact.

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e. Tighten set screw 9655 to lock pin in position in the saddle casting 133645.

f. Tighten nut 16229, aligning slot in nut with hole in pin. Insert cotter pin 8898 through the nut and pin. Nut should be snug prior to locking in place.

g. Remove shim from between pin and screw head.

14. TRENDELENBURG HAND CRANK (Units Shipped Before 5/72)

NOTE: Due to field complaints of Trendelenburg hand cranks continuously loosening, a change was made in the method and dimensional control of spotting the shafts for the related set screw. This change has been incorporated into all tables manufactured after 5/16/72.

Modification of Tables (Shipped Before 5/16/72): Continuously loosening hand cranks on tables manufactured prior to 5/16/72 can be modified as follows:

1. Refer to Fig. 7-2, Sheets 3 of 4 and 4 of 4 to locate the crank (A-92013-001).

2. Disassemble and rotate the affected shaft (78222) 180 degrees.

3. Using a 90-degree point, 1/4" dia. drill, spot the shaft as shown in Figure 4-3. (Note: 90 degree point drills are special and must be ordered from a local industrial supply house. An alternative would be to take a standard drill and grind it to a 90 degree point.)

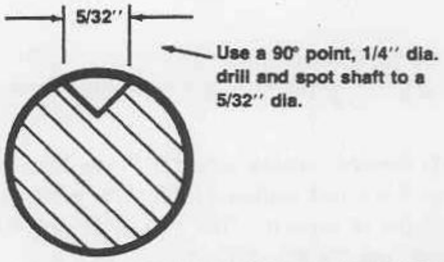
5/32''
Use a 90° point, 1/4'' dia. drill and spot shaft to a 5/32'' dia.

Figure 4-3. DRILL POINT DETAIL FOR TRENDELENBURG HAND CRANK.

15. LATERAL TILT MECHANISM (Units Shipped Before 4/76)

A newly designed lateral tilt mechanism has been incorporated into all 2080M tables manufactured after April 1, 1976. This "new" mechanism will prevent the table from sticking in full lateral tilt.

If a 2080M table manufactured before April, 1976 sticks in full lateral tilt, proceed as follows:

With selector set to Lateral Tilt, put pressure on the hub of the main hand crank assembly with the palm of one hand, while turning the crank backwards with the other hand. In this fashion, you are overcoming the clutch mechanism. Enough pressure can be exerted on the crank to back the table out of lateral tilt.

16. SHIFT LEVER MODIFICATION (Figure 7-12)

Shift lever (P-133671-001) can be modified to fit more securely as follows:

1. Remove lever and rotate shaft 180 degrees.

2. Using 90-degree point, 1/4-inch diameter drill, spot shaft as shown in Figure 4-3.

3. Modify lever as follows (see Figure 4-4):

   a. Using #7 (.201 inch) drill, drill through existing threads on lever.

   b. As shown, drill to 1/4-inch depth using 5/16-inch drill.

   c. Tap remaining depth with 1/4-20 tap.

   d. Insert 1/4-20 setscrew (P-150823-136) and fasten lever to shaft.

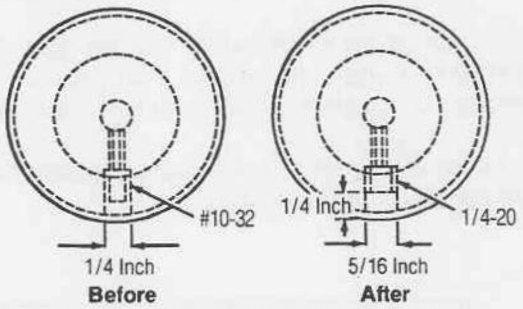

Figure 4-4. SHIFT LEVER MODIFICATION.

CHAPTER V
COMPONENT REPLACEMENT

NOTE: This chapter provides procedures for removing assemblies and detail parts from the table. Reassembly is essentially the reverse of disassembly and may be accomplished by referring to the exploded view illustrations included in Chapter VII. After replacing a part, perform the appropriate inspection and maintenance procedures in Chapter IV. Always perform applicable testing after replacing a hydraulic component.

1. REMOVING SUPERSTRUCTURE FROM BASE

a. Engage floor locks.

b. Lift and support base cover as previously described in Chapter IV, paragraph 1a (see **WARNING** on page 4-1).

c. Remove four screws 46123 (figure 7-18, sheet 2) and remove shroud cover 99425. Lower shrouds 99326 and 99327 onto base cover.

d. Refer to figure 7-21 and disassemble the rollers from ONE side of the square steel guide bar, removal of rollers from only one side will aid reassembly. Parts to be removed are set screws 43223, nuts 78314, cams 46478, shaft 77527, spacers 77526 and 46485, and rollers 46572 in order of disassembly. Rollers and spacers will fall free when shaft is removed.

e. Depress "RAISE/LOWER" pedal and force lift cylinder to minimum height.

f. Release floor lock and roll base out from under superstructure.

2. HEAD SECTION

a. Loosen knobs 77559 (figure 7-2, sheet 1).

b. Pull head section 133688 (figure 7-2, sheet 1) from back section.

3. BACK SECTION

a. Remove screws 9282 (figure 7-2, sheet 1) and washer 16438 to disconnect the back section from lever arm assembly 55114-001.

b. Back off on set screws 25834 (figure 7-2, sheet 1) which lock pivot pins 44440 in position.

c. Disconnect back section 55105 (figure 7-2, sheet 1) at the seat section by removing pivot pins 44440.

d. To remove back section side rails, refer to figure 7-5.

4. LEG SECTION

a. Remove screws 9282 (figure 7-2, sheet 1) and washers 16438 to disconnect the leg section from lever arm assembly 55114-002.

b. Back off on set screws 25834 (figure 7-2, sheet 1) which lock pivot pins 43337 in position.

c. Disconnect leg section 55104 (figure 7-2, sheet 1) at the seat section by removing pivot pins 43337.

d. To remove leg section side rails, refer to figure 7-3.

5. SEAT SECTION

a. Disconnect pivot points of leg and back sections as described in paragraphs 3 and 4 of this chapter.

b. Pull off button 26577 (figure 7-2, sheet 1) underneath the seat section from each side.

c. Back off screw 43240 (figure 7-2, sheet 1).

d. Rotate eccentric 16235 (figure 7-2, sheet 1) as necessary to loosen it and pull out pin 16215 on each side. Seat section will drop free.

e. Tilt seat section 55100 to lift free of the superstructure. Seat section may be removed from superstructure without removing gear 16290 (figure 7-4).

f. To remove seat section side rails, refer to figure 7-4.

6. BASE COVER AND SHROUDS

a. Remove superstructure as described in paragraph 1 of this chapter.

b. Remove shrouds 99326 and 99327 (figure 7-18, sheet 2).

c. Remove cover 99324 (figure 7-18, sheet 2).

7. PUMP ASSEMBLY

a. Lift and support the base cover as described in paragraph 1a of Chapter IV (see **WARNING** on page 4-1).

b. Remove socket head screws 37891 (figure 7-19) and lockwasher 19685 securing cover 77507 and remove cover and gasket 77506 from sump 99310.

c. Reach down inside sump and disconnect hydraulic fitting 45565 (figure 7-19) from pump assembly 55087 (figure 7-19).

d. Remove four socket head screws 13411 (figure 7-19) and lift pump assembly 55087 from sump 99310.

8. RAISE/LOWER PEDAL

a. Lift and support the base cover as described in paragraph 1a of Chapter IV (see **WARNING** on page 4-1).

b. Remove base plate 99386 (figure 7-18, sheet 1) by removing attaching screws 16383 and washers 5503, and washers 19680.

CAUTION: When moving pump and sump assembly, be careful not to make any sharp bends in the copper tubing.

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c. Remove screws 11266 and washers 19678 (figure 7-18, sheet 1) and shift pump and sump assembly slightly to provide access to the pedal.

d. Remove pedal 133637 (figure 7-18, sheet 1) by removing attaching screws 12551 and washers 36628.

9. ELEVATING CYLINDER

Most leather cup seals do not meet the design specifications. The result is leaky and noisy lift cylinders. To correct this situation, units shipped after November, 1977 are equipped with "new" lift cylinders.

When it becomes necessary to replace the "old" lift cylinder on a Table shipped before November, 1977, order P-136375-001 (Figure 7-23). The "old" lift cylinder on Figure 7-18 is either 133634-002 or 135940-002.

Do not attempt to rebuild the lift cylinder; replace the entire assembly. Order and install lift cylinder, P-136375-001. Return defective lift cylinder to Service Company.

a. Lift and support the base cover as described in paragraph 1a of Chapter IV (see **WARNING** on page 4-1).

b. Depress the RAISE/LOWER pedal to the floor and force cylinder pistons 133634 or 135940 (figure 7-18, sheet 1) all the way down to vacate oil out of the cylinder. This will prevent spilling of oil when the line is broken.

c. Break the hydraulic line to fitting 52737 at the base of lift cylinder 133634 or 135940 and also break the hydraulic line to fitting 7030 on the return line from the collector can.

d. Remove lift cylinder 133634, 135940, or 136375 by removing four screws 13796 (figure 7-18, sheet 1) and washers 19680 that secure the lift cylinder to the base assembly.

10. FLOOR LOCKS

NOTE: With the exception of replacing foot 150199 (figure 7-22, sheet 1), the disassembly procedures described in this paragraph require that the base cover be raised and supported (see paragraph 1a of Chapter IV and **WARNING** on page 4-1). It may be necessary to tilt the table for access to parts on the underside of the base assembly.

a. Pin and Foot Assembly. Pin and foot assembly 150202 (figure 7-22, sheet 1) contains a foot 150199 and a rod (41530) which may be replaced. To replace foot 150199 proceed as follows:

(1) Engage floor lock by depressing the LOCK pedal.

(2) Tilt table as necessary to provide access to foot which is to be removed. For instance, if it is desired to replace a foot on the right side of table, tilt table top to the left.

NOTE: There is a flat on foot 150199 which allows using a wrench to turn the foot off of rod 41530. Depressing the LOCK pedal will force the rod down and expose the flat.

(3) Remove foot 150199 (figure 7-22, sheet 1) from rod 41530 by turning counterclockwise.

To remove rod 41530 (figure 7-22, sheet 1) proceed as follows:

NOTE: The two linkages overlap each other. When removing linkages from base assembly, first remove linkage that overlaps the other. Then remove the second linkage.

(1) Disconnect spring 24833 (figure 7-22, sheet 1) and back out screw 10585.

(2) Remove screw 82481-001 or 77722 (figure 7-22, sheet 1) and pull linkages 92524-001 or 77725 and 82479-001 or 77727 free of rod 41530.

(3) Tilt the table and remove sleeve bearing 82633 from rod 41530.

(4) Then pull rod 41530 through the bottom of the base assembly.

b. Spring 80117

NOTE: Replacement of spring 80117 (figure 7-22, sheet 2) may be required if the LOCK pedal does not return to raised position after pedal is depressed and then released, and this cannot be adjusted by screw 79593 (figure 7-18, sheet 1). The possibility of mechanical interference should also be checked.

(1) Remove set screw 80196 (figure 7-22, sheet 2) from the top of base assembly and check to see if spring 80117 can be removed through hole in top of base assembly.

(2) If spring 80117 cannot be removed from the top of the base assembly, lift base with a hoist or tilt table and support.

(3) Remove bearing blocks 78203 by removing attaching screws 31838 and washers 19680.

(4) Lower shaft assembly 55084 to provide access to spring 80117.

c. Pedal

(1) Repeat step (1) through (4) of paragraph 10b of this chapter to lower shaft assembly 55084 (figure 7-22, sheet 2).

(2) Back out set screw 40006 in cam 77731 and remove cam from pedal end of shaft.

(3) Pull bearing blocks 78203 from shaft assembly 55084.

(4) Remove set screw 40006 (figure 7-22, sheet 2) and remove pedal assembly 133633 by sliding from the shaft.

d. Cam Roller. Remove cam roller 45272 (figure 7-22, sheet 1) by removing attaching nuts 2945 and washers 43754 and 19680.

e. Casters

(1) Tilt table and support.

(2) Remove nut 13397 (figure 7-22, sheet 2) and washer 19681 attaching caster 36584 to the base assembly.

(3) Remove caster by dropping out the bottom of the base assembly.

f. Caster Extension

NOTE: Installation of caster extension kit 605504 (figure 7-22) may be required if existing casters fail to clear pivot mount.

(1) Raise base cover to gain access to floor lock assembly and caster bolts, as described in paragraph 6 of this chapter.

(2) Remove pin and foot assembly and casters as described in paragraphs 10a and 10e of this chapter.

(3) Place spacer 83745 on caster 93313 and install onto base as standard caster.

NOTE: Spacer must be positioned between base and caster.

(4) Install pin and foot assembly 83748, and lower table base.

(5) Reinstall floor lock bars and shoulder bolts.

(6) Secure base cover.

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11. LIFT CARRIAGE ASSEMBLY

a. Bearing Slides

(1) Remove the superstructure as described in paragraph 1 of this chapter.

(2) With table support assembly 133636 now off column 55131 (figure 7-18, sheet 1), bearing slides 77528 (figure 7-18, sheet 1) will slide off pins 16250 (figure 7-21).

b. Cams and Rollers. With the table support assembly removed from the main column as described above, disassembly of the cams and rollers can be accomplished by referring to figure 7-21.

12. SIDE TILT ASSEMBLY

(1) Remove superstructure and lift carriage as described in this chapter, paragraph 11. Refer to figure 7-2, sheet 2.

(2) Remove nut 80915, gears and thrust bearings.

(3) Disassemble from side frame. Further disassembly of this unit can be accomplished by referring to figure 7-10.

13. TRENDELENBURG DRIVE

a. Handcrank and Tilt Indicator. Remove set screw securing hand crank 92013 (figure 7-2, sheet 3 or 4). Remove hand crank and tilt indicator 80904 by pulling free of shaft.

b. Shaft and Bearing Assembly.

NOTE: Removal of the shaft and bearing assembly provides access to the trendelenburg worm and sector and bevel gears.

(1) Remove cover 133665 (figure 7-2, sheet 3 or 4) by removing screws 30379 and nuts 47161.

(2) Remove set screw 77561 (figure 7-2, sheet 3) and remove ratchet handle assembly 55269 by pulling from kidney drive shaft assembly 55982.

or

Remove pin 41510 (figure 7-2, sheet 4) and remove kidney elevator crank assembly 92588 from shaft and bearing assembly 133676. Remove pin 43227 (figure 7-2, sheet 4). Slide coupling 77552 (figure 7-15A) back on shaft 77551 (figure 7-15A) to free shaft and bearing assembly from shaft 77551 (figure 7-2, sheet 4).

(3) Remove handcrank 92013 (figure 7-2, sheet 3 or 4) by removing set screw 80001.

(4) Slide washer 80905, indicator 80904, and spacer 20197 from shaft 78222 (figure 7-2, sheet 3) or shaft and bearing assembly 13376 (figure 7-2, sheet 4).

(5) Remove bezel 55135 (figure 7-2, sheet 3 or 4) by removing screws 3984.

(6) Remove cover 133668 (figure 7-17) by removing screws 81291 and 55281-004.

(7) Remove screw 80222, lock washer 19687, washers 3516, and nut 3099 (figure 7-2, sheet 3 or 4).

(8) Remove screw 5895, nuts 3099 and washers 3516 (figure 7-2, sheet 3 or 4).

(9) Remove screw 55281-005 (figure 7-2, sheet 3 or 4) and pull shaft and bearing assembly 133676 from side frame. Disassembly of the trendelenburg shaft and bearing assembly may be accomplished by referring to figure 7-14 or 7-14A.

14. KIDNEY ELEVATOR (Units Shipped Before 8/74)

a. Ratchet Handle Assembly. Remove set screw 77561 (figure 7-2, sheet 3) and remove ratchet handle assembly 55269 (figure 7-2, sheet 3) by pulling from kidney drive assembly 55982. When replacing set screw 77561, first bottom screw and then back it out 1/4 turn.

b. Shaft Assembly. Remove pin 43227 (figure 7-2, sheet 3) to release drive shaft assembly 55982. Slide universal joint back on shaft to free shaft assembly.

c. Kidney Drive Shaft Assembly.

NOTE: Removal of the kidney drive shaft assembly provides access to the kidney elevator drive gears.

(1) Remove cover 133665 (figure 7-2, sheet 3) by removing screw 30379 and screws 46123.

(2) Disassemble shaft assembly as described in paragraph 14b of this chapter.

(3) Remove handle 92013 (figure 7-2, sheet 3) by removing set screw 80001.

(4) Slide washer 80905, indicator 80904, and spacer 20197 from shaft 78222 (figure 7-2, sheet 3).

(5) Remove bezel 55135 (figure 7-2, sheet 3) by removing screws 3984.

(6) Remove cover 133668 (figure 7-17) by removing screws 81291 and 55281-004.

(7) Removing cover 133668 will expose area containing the drive assembly. To remove drive assembly from the side frame, remove screws 46124 (figure 7-2, sheet 3). Disassembly of the drive assembly may be accomplished by referring to figure 7-15.

d. Gear Box

(1) Remove Kidney Elevator Rack Assembly 22266 by backing out two set screws 25834 (figure 7-2, sheet 1) in side rail link 78200. Remove pins 44440 (figure 7-2, sheet 1) and remove one pin from universal joint adjacent to gear box. Lift assembly out of the table.

(2) Refer to figure 7-2, sheet 1 and remove parts 78200, 16578, 52715, 52716 and shims. Back out screw 3967 (figure 7-2, sheet 3) and turn 16285 (figure 7-2, sheet 1) counterclockwise to remove. Slide shaft 76253 through 53328 far enough to expose gear 16247. Remove pin 24700 securing gear to shaft. Gear box may then be removed.

15. KIDNEY ELEVATOR (Units Shipped After 8/74)

a. Kidney Elevator Crank Assembly. Remove pin 41510 (figure 7-2, sheet 4) and remove kidney elevator crank assembly 92588 by pulling from shaft and bearing assembly 133676.

b. Trendelenburg Support Assembly. Perform the procedures of paragraph 13b of this chapter to remove shaft and bearing assembly from side frame. Disassembly of Trendelenburg support assembly from shaft and bearing assembly can be accomplished by referring to figures 7-14A and 7-15A.

c. Gear Box

(1) Remove Kidney Elevator Rack Assembly 22266 by backing out two set screws 25834 (figure 7-2, sheet 1) in side rail link 78200. Remove pins 44440 (figure 7-2, sheet 1) and remove one pin from universal joint adjacent to gear box. Lift assembly out of the table.

(2) Refer to figure 7-2, sheet 1 and remove parts 78200, 16578, 52715, 52716 and shims. Back out screw 3967 (figure 7-2, sheet 4) and turn 16285 (figure 7-2, sheet 1) counterclockwise to remove. Slide shaft 76253 through 53328 far enough to expose gear 16247. Remove pin 24700 securing gear to shaft. Gear box may then be removed.

16. SIDE DRIVE ASSEMBLY

a. Drive Crank Assembly. Refer to figure 7-2, sheet 2 and remove the plug button 25890. A tab on washer 81129 is bent up into slot on nut 81128. Straighten tab and remove nut. Handle will now pull off. During reassembly, adjust clutch as described in paragraph 8, Chapter IV.

b. Shift Lever Assembly. To remove shift lever assembly 55093 (figure 7-2, sheet 2), it is first necessary to remove drive crank assembly 92016 as described above. After drive crank has been removed, remove the shift lever assembly by removing two set screws in the lever. Disassembly of shift lever assembly 92016 may be accomplished by referring to figures 7-12 and 7-2, sheet 2.

NOTE: Main drive shaft 54611 (figure 7-9E) must be removed from end of side frame opposite drive crank.

(1) Remove end-drive cap 133655 (figure 7-17) from end of side frame opposite drive crank by removing screws 55281-003.

(2) Remove taper pins 14394 (figure 7-9E) from clutches 16185 and 16198. The three clutches are exposed for pin removal by shifting drive shaft to different positions.

(3) Remove pin 15338 (figure 7-9E) securing spool shifter 16254.

NOTE: Mark shaft 54611 before removing to enable returning to correct position and note location of the longer clutch to insure correct reassembly.

(4) Remove shaft 54611 (figure 7-9E) by pulling out through opening in end of side frame. As shaft is removed from the side drive assembly, clutches 16185 (two used) and 16198 will fall free.

c. Gears and Bearing Block. Perform the procedures of paragraph 16b of this chapter to remove the main drive shaft and clutches from side drive assembly 99930-002 (see Note 2 on figure 7-2). Disassembly of all table top positioning gears and bearing block can be accomplished by referring to figure 7-2, sheet 2 and figure 7-9.

NOTE: When removing worm gears in the back or foot section, it is necessary to release eccentrics by turning away from worm. Replacement of a worm gear in the seat section requires that the seat section be removed as described in paragraph 5 of this chapter.

17. RADIOGRAPHIC TOPS

In 1976 the thickness of the radiographic tops was changed from 1/2 inch to 7/16 inch. When replacing only one section of a 1/2-inch-thick top with a 7/16-inch-thick section, insert a 1/16 inch, plain washer (for example P-31932-061) between the thinner board and each leg that it rests on.

18. RELIEF VALVE

New relief valve P-150631-001 supersedes old relief valve P-77540-091. (See Figure 7-20.)

The new relief valve is a disc type with soft seat that eliminates the possibility of high-pitched valve squeal when the table is lowered from maximum height.

When replacing old relief valve, order new relief valve P-150631-001 and elbow P-45407-091. The elbow is required because the new valve has a different hole size.

19. LEG SECTION (2080M I.A.) — Refer to Figure 7-24.

a. Remove set screws and hinge pins joining Leg Section and Seat Section side rails.

b. Remove two flat head screws joining Leg Section with Lever Arm Assembly.

c. Remove Leg and Head/Foot Sections from table.

20. HEAD/FOOT SECTION (2080M I.A.) — Refer to Figure 7-24.

a. Remove pad.

b. Remove four truss head screws.

c. Remove top plate with the two inserts.

d. Actuating/locking mechanism and ratchet assemblies are now easily accessible.

CHAPTER VI
LUBRICATION

The table below lists gears, worms, gear sectors, and other items which require periodic lubrication. The table provides a reference to the illustration where the part may be located and indicates the time interval at which the part must be lubricated. For ease of location, lubrication points are indicated in the right-hand column of the exploded views in Chapter VII, adjacent to the applicable part. Refer to the applicable note indicated in the table for applicable lubricant.

NOTES:

1. Lubricate with Moly-Lubriplate type MS HD No. 2 (Order specification P-753975-091, 5 pound can).

2. Lubricate with Lubriplate type 630 AA (ordering specification RM 6400-140, 5 pound can).

3. Apply a light coat of a good grade of medium-weight lubricating oil to the inner diameter of sleeve bearings, the faces of thrust bearings, shafts, and other moving parts when replacing a part.

4. Coat the sides of the square column on which the rollers do not roll with Moly-Lubriplate. Do not lubricate sides of the column on which the rollers roll.

5. Lubricate the reamed holes where rods 41530 come up through base casting with Moly-Lubriplate.

6. Lubricate linkages 77725 or 92524 and 77727 or 82479 where they interlock with rods 41530. Lubricate with Moly-Lubriplate.

LUBRICATION

ITEM	INTERVAL	FIG. REF.	SEE NOTE
Shaft 76253	6 Mo.	7-2(1)	2
Spur gear 15220	6 Mo.	7-2(1)	2
Shaft 78222			
Needle bearing 16405	6 Mo.	7-2(3 & 4)	1
Thrust bearing 44766	6 Mo.	7-2(3 & 4)	2
Shaft 92014	6 Mo.	7-2(2)	1
Needle bearing 16233	3 Mo.	7-2(2)	1
Gear 16102	3 Mo.	7-2(2)	1
Shaft 77565	6 Mo.	7-3 & 7-5	2
Worm sector 16290	3 Mo.	7-4	1
Rod 42732	6 Mo.	7-6	2
Pin 16266	6 Mo.	7-7 & 7-8	2
Worm gear 16108	3 Mo.	7-7	1
Worm gear 16106	3 Mo.	7-8	1

Service Bulletin Number						

LUBRICATION (Continued)

ITEM	INTERVAL	FIG. REF.	SEE NOTE
Shaft 54611	3 Mo.	7-9E	1
Bearing 43323	3 Mo.	7-9B	1
Needle bearing 16271	3 Mo.	7-9B	1
Thrust bearing 16204	3 Mo.	7-9B	1
Worm gear 16105	3 Mo.	7-9B	1
Bearing 43213	3 Mo.	7-9A	1
Needle bearing 16233	3 Mo.	7-9B & 7-9C	1
Gear 22728	3 Mo.	7-9A	1
Worm gear 16109	3 Mo.	7-9D	1
Needle bearing 16213	3 Mo.	7-9C	1
Bearing 43217	3 Mo.	7-9C	1
Ball bearing 16281	3 Mo.	7-9C	1
Ball bearing 16209	3 Mo.	7-9D	1
Bearing 80112	6 Mo.	7-10	1
Universal joint 92947	6 Mo.	7-10	3
Screw 92945	6 Mo.	7-10	1
Needle bearing 16182	6 Mo.	7-14 & 7-14A	1
Inner race 80189	6 Mo.	7-14 & 7-14A	1
Worm gear 77639	6 Mo.	7-14 & 7-14A	1
Bearing race 76549	6 Mo.	7-14 & 7-14A	1
Needle bearing 75828	6 Mo.	7-14 & 7-14A	1
Inner race 80191	6 Mo.	7-14 & 7-14A	1
Needle bearing 80190	6 Mo.	7-14 & 7-14A	1
Universal joint 76543	6 Mo.	7-14	3
Shaft 80188	6 Mo.	7-14	1
Shaft 80214	6 Mo.	7-14A	1
Bevel gear 23892	6 Mo.	7-14A	1
Gear 77572	6 Mo.	7-15	1
Shaft 77574	6 Mo.	7-15	1
Gear 77571	6 Mo.	7-15	1
Universal joint 20200	6 Mo.	7-15 & 7-15A	3
Bearing, thrust 50713	6 Mo.	7-15A	1
Bearing flange 32307	6 Mo.	7-15A	1
Shaft 82607	6 Mo.	7-15A	1
Ratchet 78220	6 Mo.	7-16	2
Table Support Assembly	6 Mo.	7-21	4
Shaft 77527	6 Mo.	7-21	1
Bearing 46572	6 Mo.	7-21	1
Rods 41530	3 Mo.	7-22(1)	5
Guide 77725 or 92524	3 Mo.	7-22(1)	6
Bar 77727 or 82479	3 Mo.	7-22(1)	6
Casters 36584	6 Mo.	7-22(2)	2
Pin 79878	3 Mo.	7-22(2)	1
Pin 77524	3 Mo.	7-22(2)	1

CHAPTER VII
EXPLODED VIEWS

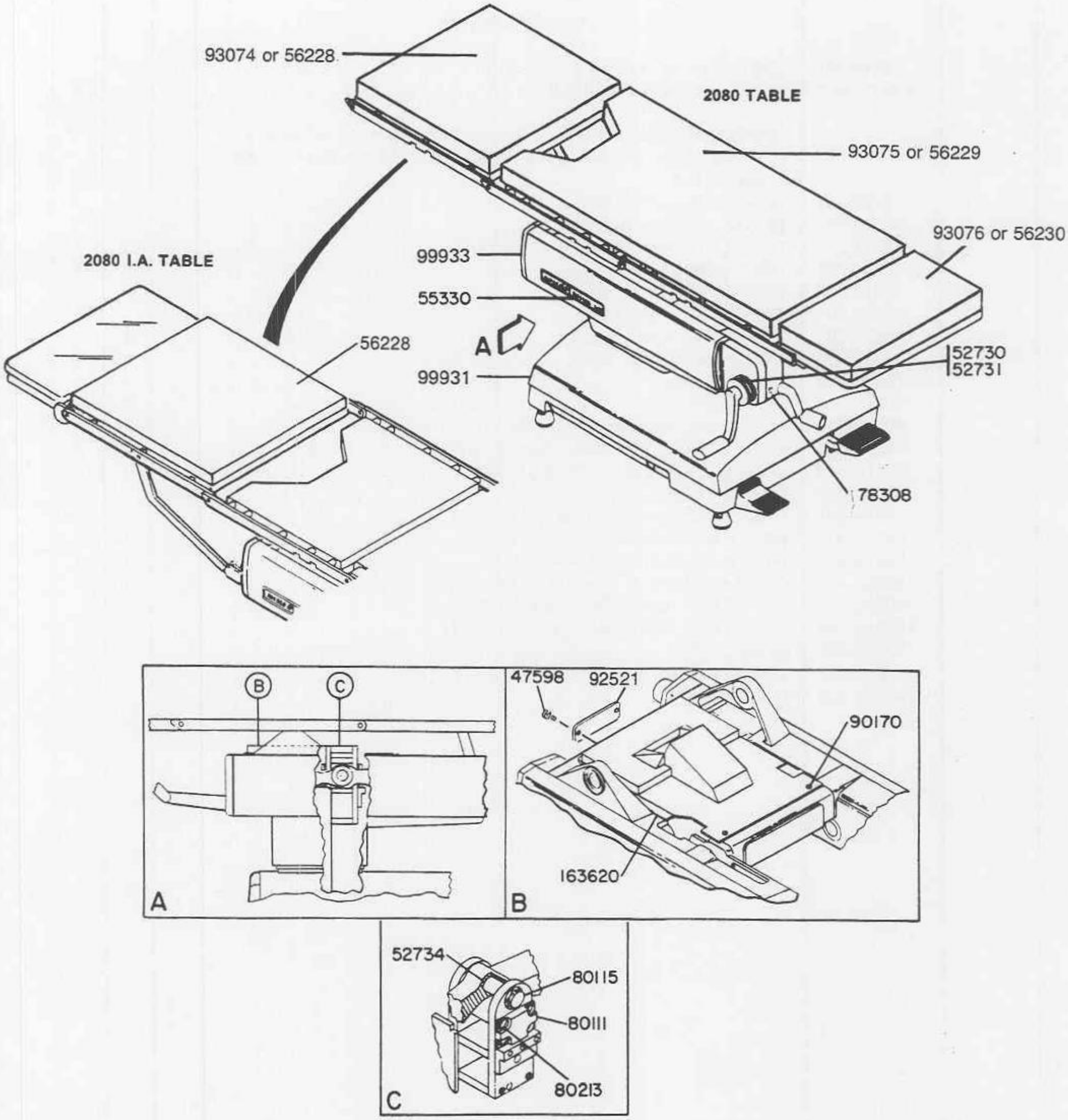
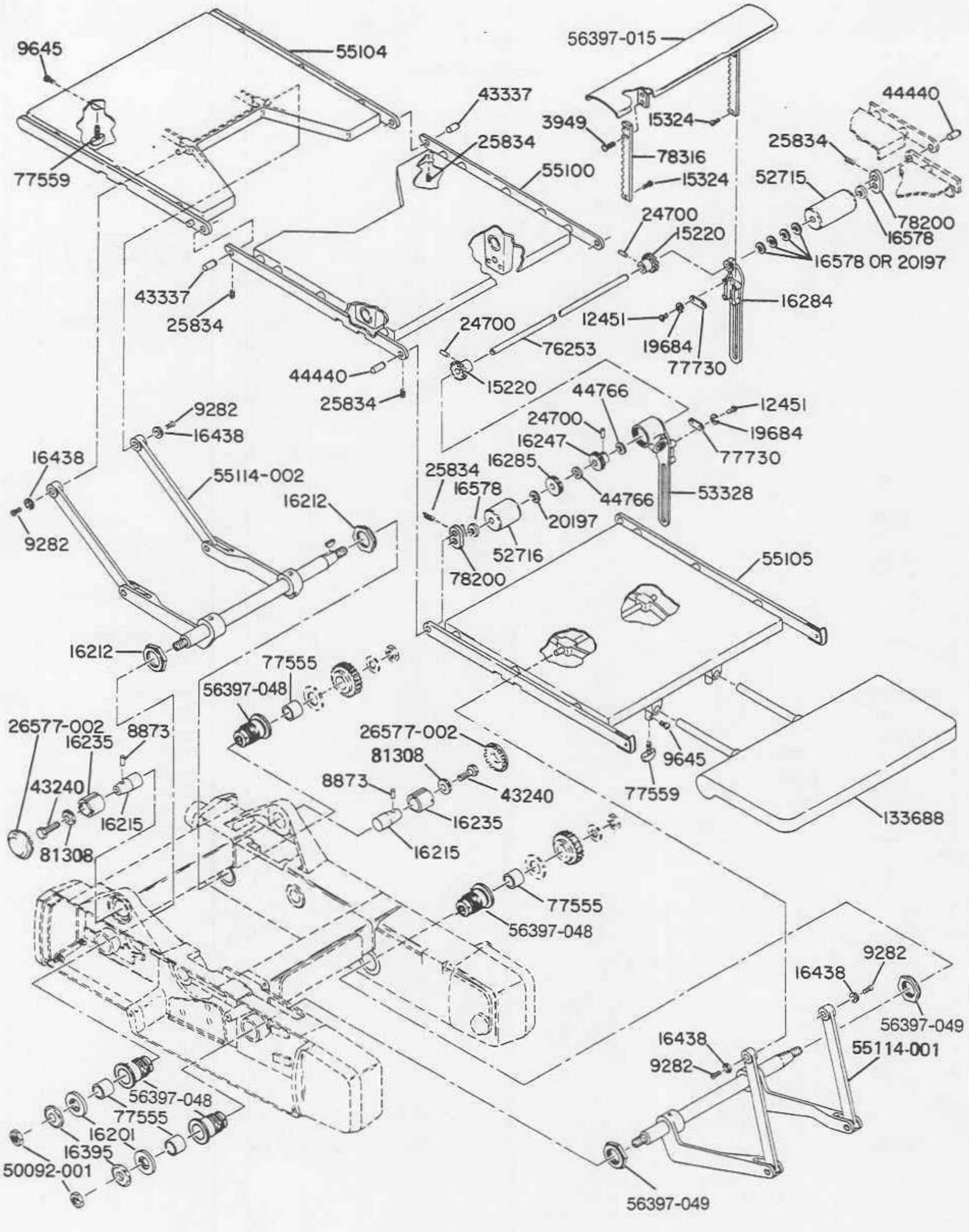

93074 or 56228
2080 TABLE
93075 or 56229
93076 or 56230
99933
55330
2080 I.A. TABLE
56228
A
99931
52730
52731
78308
B
C
A
47598
92521
90170
163620
B
52734
80115
80111
80213
C

Figure 7-1. 2080 MANUAL TABLE ASSEMBLIES.

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-1				
	99418-091	2080 MANUAL TABLE ASSEMBLY	X			
	146645-507	2080M I.A. TABLE ASSEMBLY		X		
		TAPE, Neoprene Scot Mount Pressure Sensitive, 1-1/4" wide x 1-1/32" thick, double coated) R-7200-212 is for a 72 yard long roll of tape	A/R	A/R		
	47598-061	SCREW, Drive, RD. HD.	2	2		
	52730-091	DECAL, Position Indicator	1	1		
	52731-091	DECAL, Trendelenburg Tilt Indicator	1	1		
	52734-061	PIN, Support	1	1		
	55330-091	DECAL, AMSCO Logo	2	2		
	56228-001	PAD, Foot, 1-inch Thick	1	1		
	56229-001	PAD, Back, 1-inch Thick	1	1		
	56230-001	PAD, Head, 1-inch Thick	1	1		
	78308-010	LEVEL, Target	1	1		
	80111-010	PLATE, End	2	2		
	80115-045	NUT, Hexagon Thin, 3/4-16, Steel	1	1		
	80213-045	SCREW, Button HD. Soc., Nylock, 1/4-20 x 1-1/2, Steel	8	8		
	90170-045	SCREW, Self Tapping, 8 x 5/16, Steel	4	4		
	92521-001	NAMEPLATE	1			
	93074-001	PAD, Foot, 2-inches Thick	1	N/A		
	93075-001	PAD, Back, 2-inches Thick	1	1		
	93076-001	PAD, Head, 2-inches Thick	1	1		
	99931-001	BASE ASSEMBLY (See Fig. 7-18)	1	1		
	99933-002	TABLETOP ASSEMBLY (See Fig. 7-2)	1			
	146645-509	TABLETOP ASSEMBLY (See Fig. 7-24)		1		
	163620-091	SHIELD, Top	1	1		
	93902-122	DATA PLATE		1		
	93902-123	NAME PLATE		2		

Service Bulletin Number						


9645
55104
56397-015
43337
3949
15324
44440
25834
55100
78316
15324
25834
52715
77559
78200
16578
24700
15220
16578 OR 20197
16284
43337
25834
12451
19684
24700
76253
77730
44440
25834
15220
44766
24700
12451
19684
9282
16438
16247
16285
77730
16438
55114-002
25834
16578
44766
53328
16212
20197
9282
52716
55105
78200
16212
77555
56397-048
26577-002
26577-002
16235
8873
81308
43240
8873
43240
77559
9645
16215
16235
133688
81308
16215
77555
56397-048
9282
16438
56397-049
16438
55114-001
9282
56397-048
77555
16201
16395
150092-001
56397-049

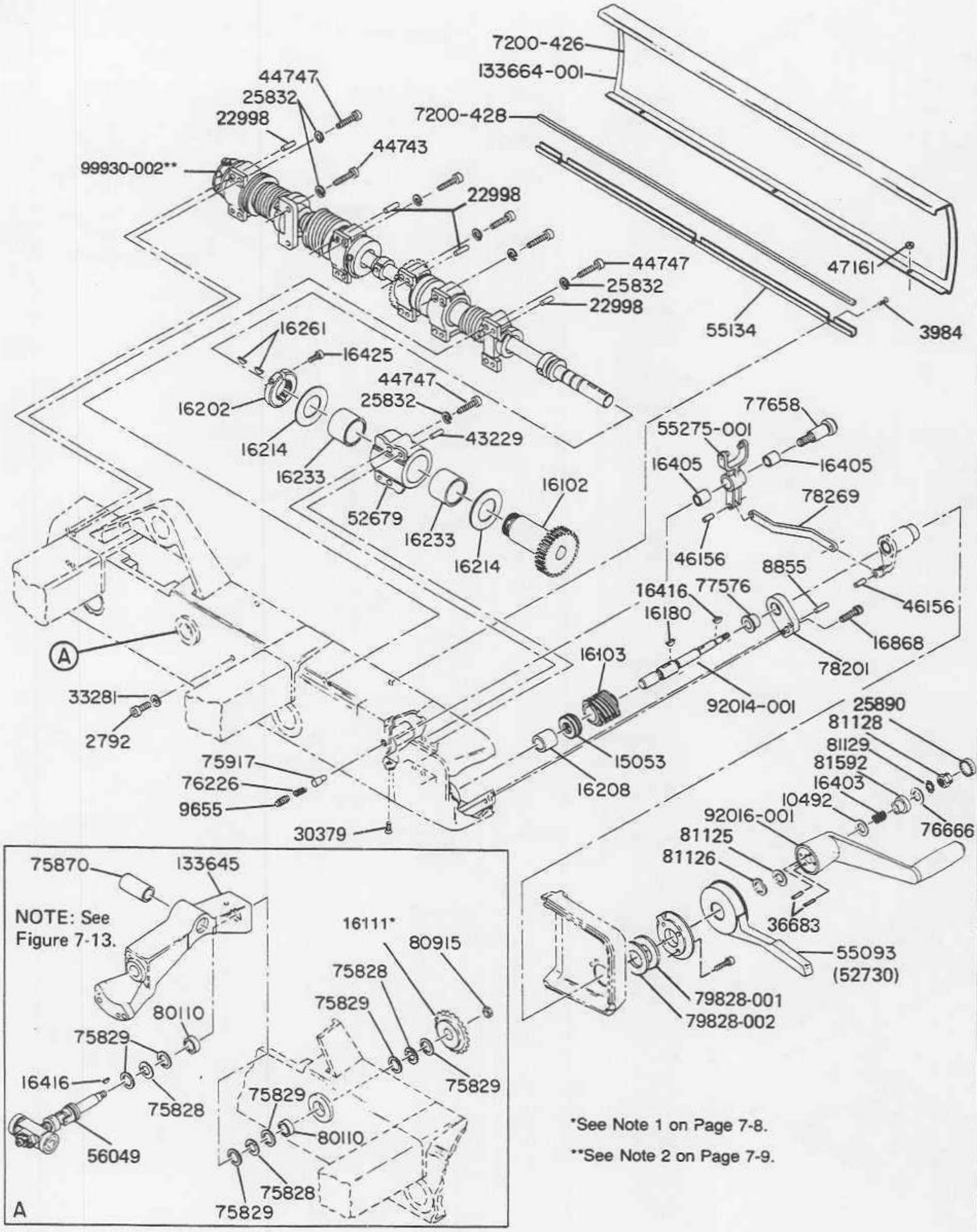
LUB.

15220

76253

Figure 7-2. TABLE TOP ASSEMBLY (99933-002) (Sheet 1 of 4).

Service Bulletin Number						


7200-426
133664-001
7200-428
44747
25832
22998
99930-002**
44743
22998
44747
25832
22998
47161
55134
3984
16261
16425
44747
25832
43229
16202
16214
16233
52679
16233
16214
16102
77658
55275-001
16405
16405
78269
46156
8855
16416
77576
16180
46156
16868
78201
16103
92014-001
Ⓐ
33281
2792
75917
76226
9655
30379
15053
16208
25890
81128
81129
81592
16403
10492
92016-001
76666
81125
81126
36683
55093
(52730)
79828-001
79828-002
75870
133645
NOTE: See Figure 7-13.
16111*
80915
75828
75829
80110
75829
16416
75828
56049
75829
75829
80110
75828
75829
A

*See Note 1 on Page 7-8.

**See Note 2 on Page 7-9.

LUB.

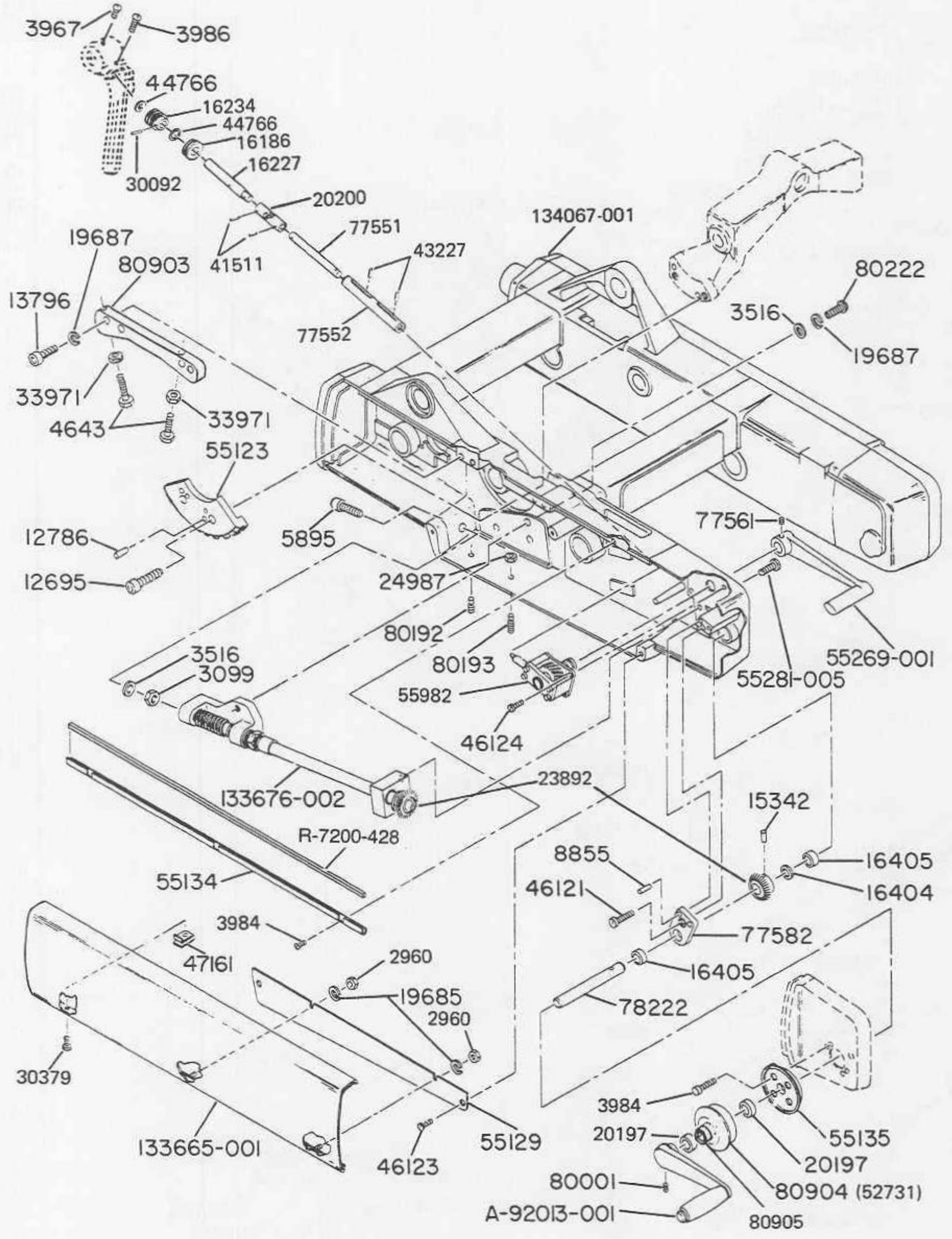
16102

16233 (2)

92014

Figure 7-2. TABLE TOP ASSEMBLY (99933-002) (Sheet 2 of 4).

Service Bulletin Number						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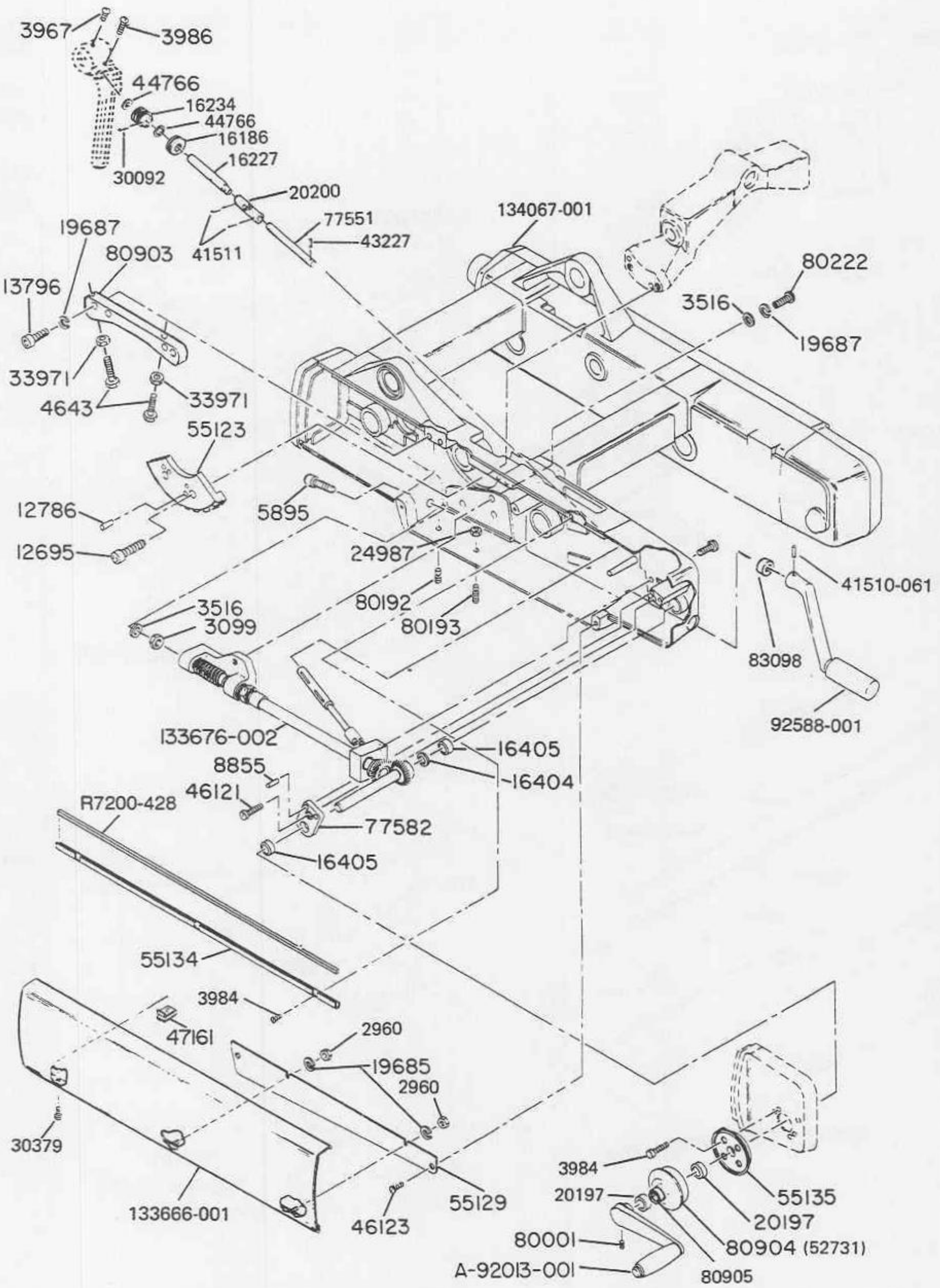
3986
44766
16234
44766
16186
16227
30092
20200
77551
41511
43227
134067-001
19687
80903
13796
77552
80222
3516
19687
33971
4643
33971
55123
12786
5895
12695
24987
77561
80192
80193
55269-001
55281-005
3516
3099
55982
46124
133676-002
23892
15342
R-7200-428
8855
55134
46121
16405
16404
3984
77582
47161
2960
16405
19685
2960
78222
30379
3984
55135
20197
20197
133665-001
46123
55129
80001
80904 (52731)
A-92013-001
80905

LUB.

44766
16234
16227
20200
77552
16405
16405

Figure 7-2. TABLE TOP ASSEMBLY (99933-002); UNITS SHIPPED BEFORE 8/74 (Sheet 3 of 4)

Service Bulletin Number						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3986
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77551
43227
41511
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13796
134067-001
80222
3516
19687
33971
4643
33971
55123
12786
12695
5895
24987
41510-061
80192
80193
3516
3099
83098
92588-001
133676-002
16405
8855
46121
16404
R7200-428
77582
16405
55134
3984
47161
2960
19685
2960
30379
133666-001
55129
46123
3984
20197
55135
20197
80001
80904 (52731)
A-92013-001
80905

LUB.

16234

44766

16227

20200

16405

16405

Figure 7-2. TABLE TOP ASSEMBLY (99933-002); UNITS SHIPPED AFTER 8/74 (Sheet 4 of 4).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-2	
	99933-002	TABLE TOP ASSEMBLY	
		(Sheet 1 of 4)	
	3949-042	SCREW, R.H. Mach., 1/4-20 x 3/4 LG., Steel	4
	8873-045	PIN, Tube Link	2
	9282-041	SCREW, RD. HD. Mach., 10-32 x 3/8, Brass	4
	9645-061	SCREW, Drive 4 x 3/16 LG., Stainless Steel	4
	12451-041	SCREW, RD. HD. Mach., 6-32 x 1/4 LG., Brass	4
	15220-045	GEAR, Spur	4
	15324-042	SCREW, RD. HD. Mach., 1/4-20 x 3/8 LG., Steel	2
	56397-050	ECCENTRIC BUSHING & LOCK ASSEMBLY	
	56397-048	• BUSHING, Eccentric	4
	56397-049	• NUT, Special Cast Locknut	4
	77555-091	• BEARING, Sleeve	4
	16201-091	WASHER, Thrust Oilite	2
	16215-091	HINGE PIN	2
	16235-045	BUSHING, Eccentric	2
	16247-091	WORM GEAR	1
	16284-042	STABILIZER, Kidney Elevator	1
	16285-042	BEARING, Special	1
	16395-091	WASHER THRUST	2
	16438-042	WASHER, Special	4
	16578-045	WASHER, 3/4 O.D. x .512 I.D. x 059 Thickness, Steel	7
	19684-061	LOCKWASHER 6, Stainless Steel	4
	20197-045	SPACER	7
	56397-015	BRIDGE ASSEMBLY	1
	24700-061	GROOVED PIN, 3/16 x 1'' L.G., ASA Type "A", Stainless Steel	3
	25834-091	SCREW, Set, Soc. Cup Point, 10-32 x 7/16, Steel	6
	26577-002	PLUG BUTTON	2
	43240-091	SCREW, Flat HD. Soc., 3/8-16 x 3/4 LG. Steel	2
	43337-063	PIN, Hinge	2
	44440-063	PIN, Hinge	2
	50713-091	BEARING, Thrust	4
	52715-091	SPACER, Long	1
	52716-091	SPACER, Short	1
	53328-042	GEAR BOX, Kidney Bridge	1
	55100-091	SEAT SECTION ASSEMBLY (See Fig. 7-4)	1
	55104-091	LEG SECTION ASSEMBLY (See Fig. 7-3)	
	55105-091	BACK SECTION ASSEMBLY (See Fig. 7-5)	1
	55114-001	BACK SECTION ARM LEVER ASSEMBLY (See Fig. 7-8)	1
	55114-002	LEG SECTION ARM LEVER ASSEMBLY (See Fig. 7-7)	1
	76253-063	CROSS SHAFT	1
	77559-056	KNOB ASSEMBLY	4
	77730-061	GEAR RACK BAR	2

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-2 (Sheet 1 of 4)	
	78200-052	LINK	2
	78320-091	KIDNEY BRIDGE RACK ASSEMBLY	2
	80930-045	LOCKNUT, Vibresist, 5/8-18, Steel	2
	81308-001	WASHER, Bevel	2
	133688-001	HEADREST ASSEMBLY (See Fig. 7-6)	1
	150092-001	NUT	2
		(Sheet 2 of 4)	
	2792-045	SCREW, Soc, HD. Cap, 1/4-20 x 1/2 LG., Steel	2
	3984-041	SCREW, Round Head, 6-32 x 3/8 LG., Steel	10
	R-7200-426	VINYL TAPE, Scotch Foam Single Coated Black, 3/8 wide x 1/8 Thick	A/R
	R-7200	VINYL TAPE, Scotch Foam Single Coated Black, 1/4 wide x 1/4 Thick (Sub: 764317-529)	A/R
	8855-091	DOWEL PIN, 1/4 Dia. x 1'' LG., Steel	4
	9655-091	SET SCREW, Allen Set Cup, Steel Point, 3/8-16 x 5/8 LG.	2
	10492-091	WASHER, 1'' O.D. x 41/64 I.D. x 1/32 Thickness, Brass	1
	15053-091	BEARING, Thrust Ball	1
	16102-091	WORM GEAR	1
	16103-091	WORM GEAR	1
NOTE 1	N.L.A. (16111)	DRIVER, Bevel Gear	1
	16180-091	WOODRUFF KEY, 11, Steel	1
	16202-091	NUT, Adjusting	1
	16208-091	BEARING, Oilite	1
	16214-091	WASHER, Thrust, Oilite	4
	16233-091	BEARING, Needle	5
	16261-091	WOODRUFF KEY, 90, Steel	8
	16403-091	SPRING	1
	16405-091	BEARING, Needle	4
	16416-091	WOODRUFF KEY, 3, Steel	2
	16425-041	SCREW, Soc. HD. Cap, 10-32 x 3/4, Brass	9
	16868-041	SCREW, Soc. HD. Cap, 3/8-16 x 3/8 LG., Steel	1
	22998-061	PIN, Spiral, 5/16 Dia. x 1-1/4 LG., Steel	8
	25832-041	LOCKWASHER, Shakeproof Internal, Steel	14
	25890-056	PLUG BUTTON	1
	30379-041	SCREW, FT. HD. 8-32 x 5/8 LG. Steel	4
	33281-061	WASHER, 11/16 O.D. X 5/16 I.D. x .031 Thickness, Stainless Steel	2
	43229-061	ROLL PIN, 3/16 Dia. x 1'' LG., Stainless Steel	2
	44743-041	SCREW, Soc. HD. Cap, 3/8-16 x 5/8 LG., Steel	2
	44747-042	SCREW, Soc. HD. Cap, 3/8-16 x 2'' LG., Steel	12
	46156-061	ROLL PIN, 5/16 x 3/4 LG.	2
	47161-091	SPEED NUT, Tinnerman Cat. C-915-832	4
	52679-001	BEARING, Main Shaft	1
	52730-091	DECAL	1
		NOTE 1: Order 22728-091 for gears 16110 (See Fig. 7-9) and 16111.	

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FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-2 (Sheet 2 of 4)	
	55093-091	SHIFT LEVER ASSEMBLY (See Fig. 7-12)	1
	55132-056	BEZEL	1
	55134-031	CHANNEL	2
	55275-001	FORK SHIFTER ASSEMBLY	1
NOTE 2	56040	SIDE TILT SCREW ASSEMBLY	1
	56049	SIDE TILT SCREW ASSEMBLY (See Fig. 7-10)	1
	75828-091	BEARING, Thrust	3
	75829-091	RACE, Thrust Bearing	6
	75870-091	SLEEVE BEARING, Oilite	1
	75917-045	PLUNGER	1
	76226-045	COMP. SPRING	1
	76666-061	WASHER, Special	1
	77576-091	FLANGE BEARING	1
	77658-091	SCREW, Shoulder, Steel	1
	78201-091	SUPPORT CROSS SHAFT	1
	78269-045	CONNECTING ROD	1
	79828-001	SPACER, .062 Thick	1
	79828-002	SPACER, .031 Thick	1
	80110-091	NEEDLE BEARING	3
	80915-045	NUT, Tensilok 3/8-16, Steel	1
	81125-001	CLUTCH, Female	1
	81126-001	CLUTCH, Male	1
	81128-001	NUT	1
	81129-001	LOCKWASHER, Special	1
	81592-001	BEARING, Crank	1
	92014-001	CROSS SHAFT	1
	92016-001	DRIVE CRANK ASSEMBLY (See Fig. 7-11)	1
NOTE 3		SIDE DRIVE ASSEMBLY (See Fig. 7-9)	1
	55970-001	SADDLE ASSEMBLY, Side Tilt	1
	133645-010	SIDE TILT SADDLE (See Fig. 7-13)	1
	133664-001	COVER, Drive Side	1
		(Sheet 3 of 4)	
	2960-042	NUT, Hex., 10-32, Steel	2
	3099-042	NUT, Hex., 3/16-18 x 3/8 Thickness, Steel	1
	3516-041	WASHER, Flat, Steel	4
	3967-041	SCREW, RD. HD. Mach., 8-32 x 1/4, Brass	1
	3984-041	SCREW, RD. HD. 6-32 x 3/8 LG.	10
	3986-041	SCREW, RD. HD. Mach., 8-32 x 1/2, Brass	1
	4643-045	SCREW, Hex. HD. Cap, 1/2-13 x 1-1/2 LG., Steel	2
	5895-048	SCREW, Soc. HD. Cap, 3/8-16 x 2" LG., Steel	1
	764317-529	VINYL TAPE, Scotch Foam Single Coated Black, 1/4 Wide x 1/4 Thick	A/R
	8855-091	DOWEL PIN, 1/4 Dia. x 1" LG., Steel	4
	12695-045	SCREW, Soc. HD. Cap, 1/2-13 x 1-1/4 LG., Steel	2
	12786-091	TAPER PIN, 7 x 1/4, Steel	2
	13796-045	SCREW, Soc. HD. Cap, 3/8-16 x 1-1/2, Steel	4
	15342-045	TAPER PIN, 3 x 1" LG., Steel	2

NOTE 2: Order 136210-001 for side tilt screw assembly 56049.

NOTE 3: 99930-002 used on units shipped before 1/75, 99930-002 deleted and parts transferred to 134186-001, 134187-001, 134188-001, 134193-001, 150124-006 and 134189-001 on units shipped after 1/75.

Service Bulletin Number

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-2 (Sheet 3 of 4)				
	16186-042	NUT, Adjusting	1			
	16227-061	SHAFT	1			
	16234-091	WORM GEAR	1			
	16404-091	WASHER THRUST, Oilite	1			
	16405-091	NEEDLE BEARING	4			
	19685-061	LOCKWASHER 10, Stainless Steel	10			
	19687-061	LOCKWASHER 3/8, Stainless Steel	7			
	20197-045	SPACER	6			
	20200-045	UNIVERSAL JOINT	1			
	23892-091	GEAR PAIR, Bevel	1			
	24987-041	NUT, Jam, 1/4-20, Steel	1			
	30092-061	PIN, Grooved, 5/32 x 3/4 LG., ASA Type "C," Stainless Steel	1			
	30379-041	SCREW, FT. HD., 8-32 x 5/8 LG., Steel	4			
	33971-091	NUT, Half Hex., 1/2-13, Brass	2			
	41511-061	PIN, Grooved, 5/32 x 5/8 LG., ASA Type "C," Stainless Steel	4			
	43227-061	PIN, Roll, 1/8 x 5/8 LG., Steel	4			
	50713-091	THRUST BEARING	4			
	46121-056	SCREW, FT. HD. Soc., 5/16-18 x 7/8	1			
	46123-010	SCREW, FT. HD. Soc., 10-32 x 1/2, Steel	2			
	46124-056	SCREW, FT. HD. Soc., 1/4-20 x 3/4, Steel	8			
	47161-091	NUT, Speed, Tinnerman, Cat. C-915-832	4			
	52731-091	DECAL	1			
	55123-091	WORM GEAR SECTOR	1			
	55129-010	PLATE, Trendelenburg Side	1			
	55134-031	CHANNEL	2			
	55135-056	BEZEL	1			
	55269-001	HANDLE RATCHET ASSEMBLY (See Fig. 7-16)	1			
	55281-005	SCREW, FT. HD. Soc., 3/8-16 x 1'', Steel	2			
	N.L.A. (55982)	KIDNEY DRIVE ASSEMBLY (See Fig. 7-15)	1			
	77551-061	KIDNEY ELEVATOR SHAFT	1			
	77552-061	COUPLING	1			
	77561-061	SCREW, Set, Allen Half Dog. 10-24 x 1/4, Stainless Steel	1			
	77582-091	DRIVE SHAFT SUPPORT	1			
	78222-061	SHAFT	1			
	80001-091	SCREW, Set, Soc. HD., 1/4-20 x 1/2, Steel	1			
	80192-091	SCREW, Swivel Head Set, 1/4-20 x 1/2, Steel	1			
	80193-091	SCREW, Swivel Head Set, 1/4-20 x 3/4, Steel	1			
	80222-061	SCREW, Button HD. Soc., 3/8-16 x 1-1/2, Stainless Steel	3			
	80903-001	SUPPORT BAR	1			
	80904-091	SELECTOR ASSEMBLY	1			
	80905-091	BEARING	1			
	92013-001	CRANK, Trendelenburg	1			
	133666-001	COVER ASSEMBLY, Trendelenburg	1			
	133676-001	SHAFT & BEARING ASSEMBLY (See Fig. 7-14)	1			
	133676-002	SHAFT & BEARING ASSEMBLY (See Fig. 7-14A)	1			
	134067-004	SIDE FRAME ASSEMBLY (See Fig. 7-17)	1			

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FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		(Sheet 4 of 4)	
	2960-042	NUT, Hex., 10-32 Steel	2
	3099-042	NUT, Hex., 3/16-18 x 3/8 Thickness, Steel	1
	3516-041	WASHER, Flat, Steel	4
	3967-041	SCREW, RD. HD. Mach., 8-32 x 1/4, Brass	1
	3984-041	SCREW, RD. HD. 6-32 x 3/8 LG.	10
	3986-041	SCREW, RD. HD. Mach., 8-32 x 1/2, Brass	1
	4643-045	SCREW, Hex. HD. Cap, 1/2-13 x 1-1/2 LG., Steel	2
	5895-048	SCREW, Soc. Hd. Cap, 3/8-16 x 2″ LG., Steel	1
	R-7200-428	VINYL TAPE, Scotch Foam Single Coated Black, 1/4 Wide x 1/4 Thick (Sub: 764317-529)	A/R
	8855-091	DOWEL PIN, 1/4 Dia. x 1″ LG., Steel	4
	12695-045	SCREW, Soc. HD. Cap, 1/2-13 x 1-1/4 LG., Steel	2
	12786-091	TAPER PIN, 7 x 1/4, Steel	2
	13796-045	SCREW, Soc. HD. Cap, 3/8-16 x 1-1/2, Steel	8
	16186-042	NUT, Adjusting	1
	16227-061	SHAFT	1
	16234-091	WORM GEAR	1
	16404-091	WASHER THRUST, Oilite	1
	16405-091	NEEDLE BEARING	4
	19685-061	LOCKWASHER 10, Stainless Steel	10
	19687-061	LOCKWASHER 3/8, Stainless Steel	7
	20197-045	SPACER	6
	20200-045	UNIVERSAL JOINT	1
	24987-041	NUT, Jam, 1/4-20, Steel	1
	30092-061	PIN, Grooved, 5/32 x 3/4 LG., ASA Type "C," Stainless Steel	1
	30379-041	SCREW, FT. HD., 8-32 x 5/8 LG., Steel	4
	33971-091	NUT, Half Hex., 1/2-13, Brass	2
	41510-061	PIN, Grooved	1
	41511-061	PIN, Grooved, 5/32 x 5/8 LG., ASA Type "C," Stainless Steel	4
	43227-061	PIN, Roll, 1/8 x 5/8 LG., Steel	1
	44766	THRUST BEARING (Sub: 50713-091)	4
	46121-056	SCREW, FT. HD. Soc., 5/16-18 x 7/8	1
	46123-010	SCREW, FT. HD. Soc., 10-32 x 1/2, Steel	2
	47161-091	NUT, Speed, Tinnerman, Cat. C-915-832	4
	52731-091	DECAL	1
	55123-091	WORM GEAR SECTOR	1
	55129-010	PLATE, Trendelenburg Side	1
	55134-031	CHANNEL	2
	55135-056	BEZEL	1

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-2 (Sheet 4 of 4)	
	55281-005	SCREW, FT. HD. Soc., 3/8-16 x 1″, Steel	2
	77551-061	KIDNEY ELEVATOR SHAFT	1
	77582-091	DRIVE SHAFT SUPPORT	1
	80001-091	SCREW, Set, Soc. HD., 1/4-20 x 1/2, Steel	1
	80192-091	SCREW, Swivel Head Set, 1/4-20 x 1/2, Steel	1
	80193-091	SCREW, Swivel Head Set, 1/4-20 x 3/4, Steel	1
	80222-061	SCREW, Button HD. Soc., 3/8-16 x 1-1/2, Stainless Steel	3
	80903-001	SUPPORT BAR	1
	80904-091	SELECTOR ASSEMBLY	1
	80905-091	BEARING	1
	83098-001	BUSHING	1
	92013-001	CRANK, Trendelenburg	1
	92588-001	KIDNEY ELEVATOR CRANK ASSEMBLY (See Fig. 7-16A)	1
	133666-001	COVER ASSEMBLY	1
	133676-002	SHAFT & BEARING ASSEMBLY (See Fig. 7-14A)	1
	134067-004	SIDE FRAME ASSEMBLY (See Fig. 7-17)	1

Service Bulletin Number						

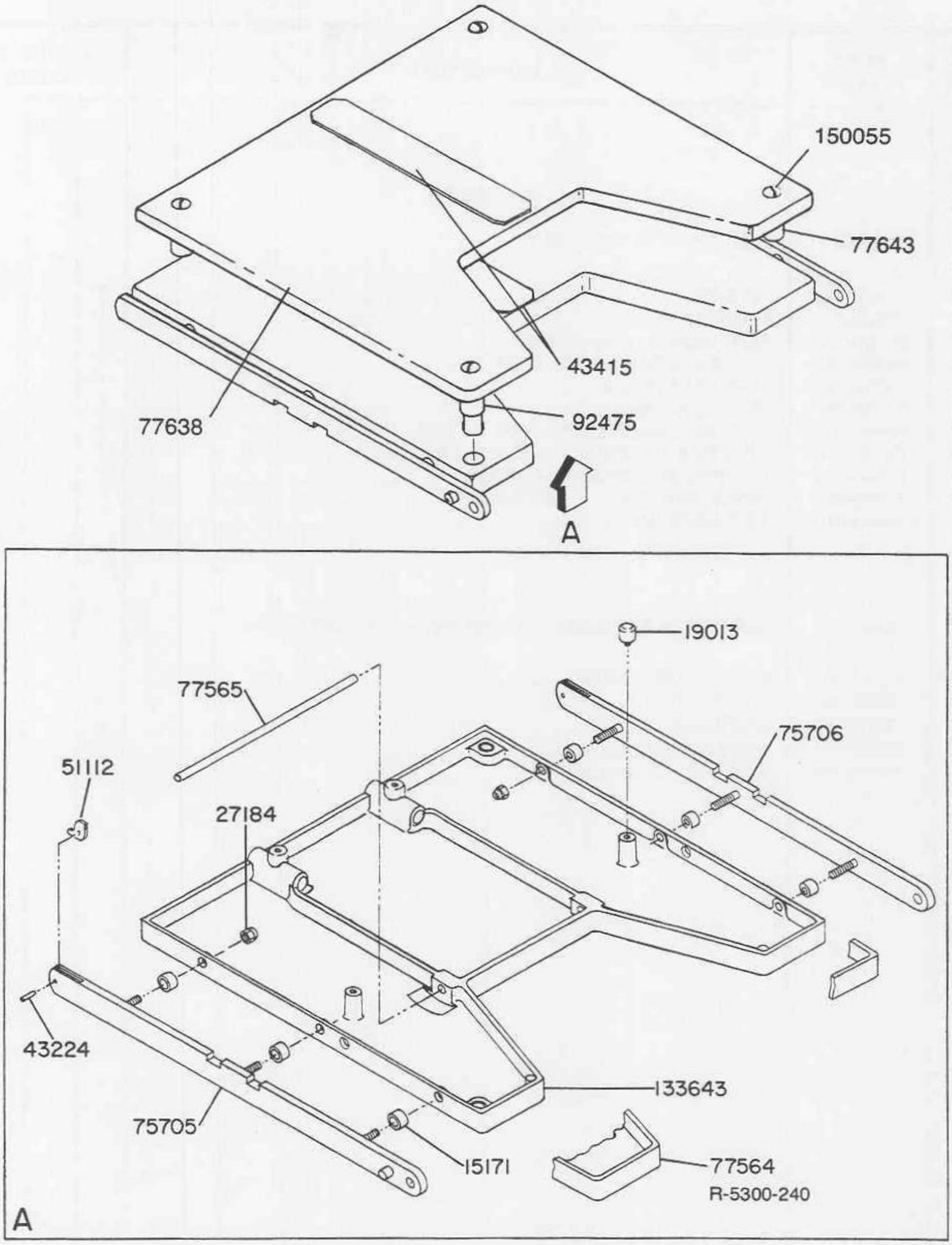
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Figure 7-3. LEG SECTION ASSEMBLY (N55104-091)

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-3				
	55104-091	LEG SECTION ASSEMBLY				
	15171-042	SPACER	6			
	19013-091	BUMPER, Rubber	2			
	27184-045	NUT, Huglock, 5/16-18, Steel	6			
	43224-061	PIN, Roll, 3/32 x 3/8 LG., Steel	2			
	43415-091	HOOK FASTENER	1			
	51112-061	SIDE RAIL CAM	2			
	75705-063	SIDE RAIL ASSEMBLY — R.H. Ft. Sect.	1			
	75706-063	SIDE RAIL ASSEMBLY — L.H. Ft. Sect.	1			
	77564-063	COVER ASSEMBLY — Leg Section	1			
	77565-061	HINGE ROD BACK — Leg Section	1			
	133643-010	LEG SECTION	1			
	55126	X-RAY TOP ASSEMBLY, LEG SECTION (Sub: 755715-170)				
	43415-091	• HOOK FASTENER	1			
	56397-069	• TOP, X-ray	1			
	77643-056	• SPACER	2			
	92475-001	• SPACER ASSEMBLY	2			
	150055-001	• SCREW, Truss Head	4			

Service Bulletin Number						

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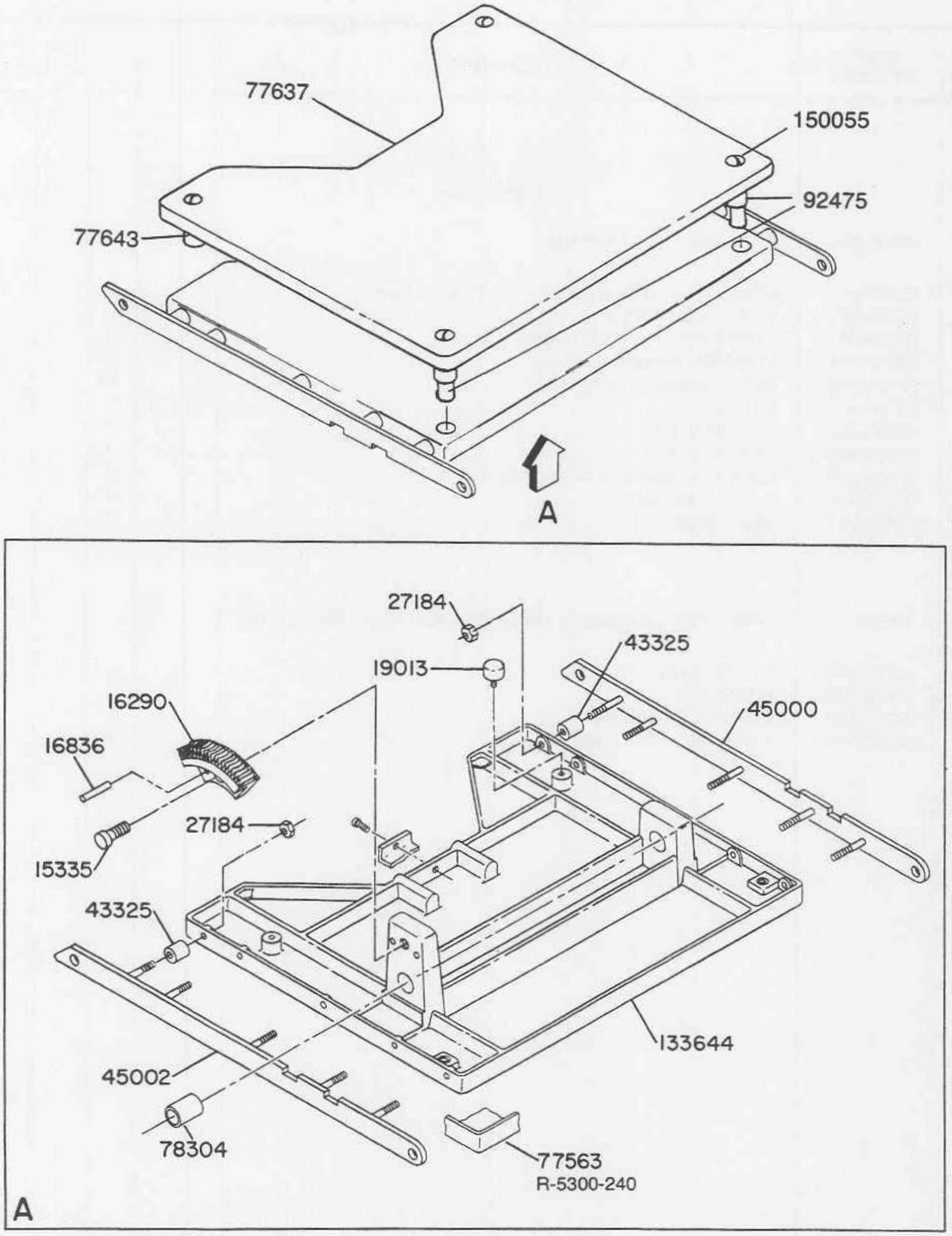
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16290

Figure 7-4. SEAT SECTION ASSEMBLY (N55100-091)

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-4	
	55100-091	SEAT SECTION ASSEMBLY	
	15335-041	SCREW, Soc. HD. Cap, 1/2-13 x 1'' LG., Steel	1
	16290-091	WORM SECTOR	1
	16836-041	TAPER PIN, 7 x 1/2 LG., Steel	2
	19013-091	BUMPER, Rubber	2
	27184-045	NUT, Heglock, 5/16-18, Steel	10
	43325-042	SPACER	10
	45000-063	SIDE RAIL L.H.	1
	45002-063	SIDE RAIL R.H.	1
	77563-063	COVER ASSEMBLY — Seat Section	1
	78304-091	SLEEVE BEARING	2
	133644-010	SEAT SECTION	1
	55127	X-RAY TOP ASSEMBLY, SEAT SECTION (Sub: 755715-227)	
	56397-068	● TOP, X-ray	1
	77643-056	● SPACER	2
	92475-001	● SPACER ASSEMBLY	2
	150055-001	● SCREW, Truss Head	4

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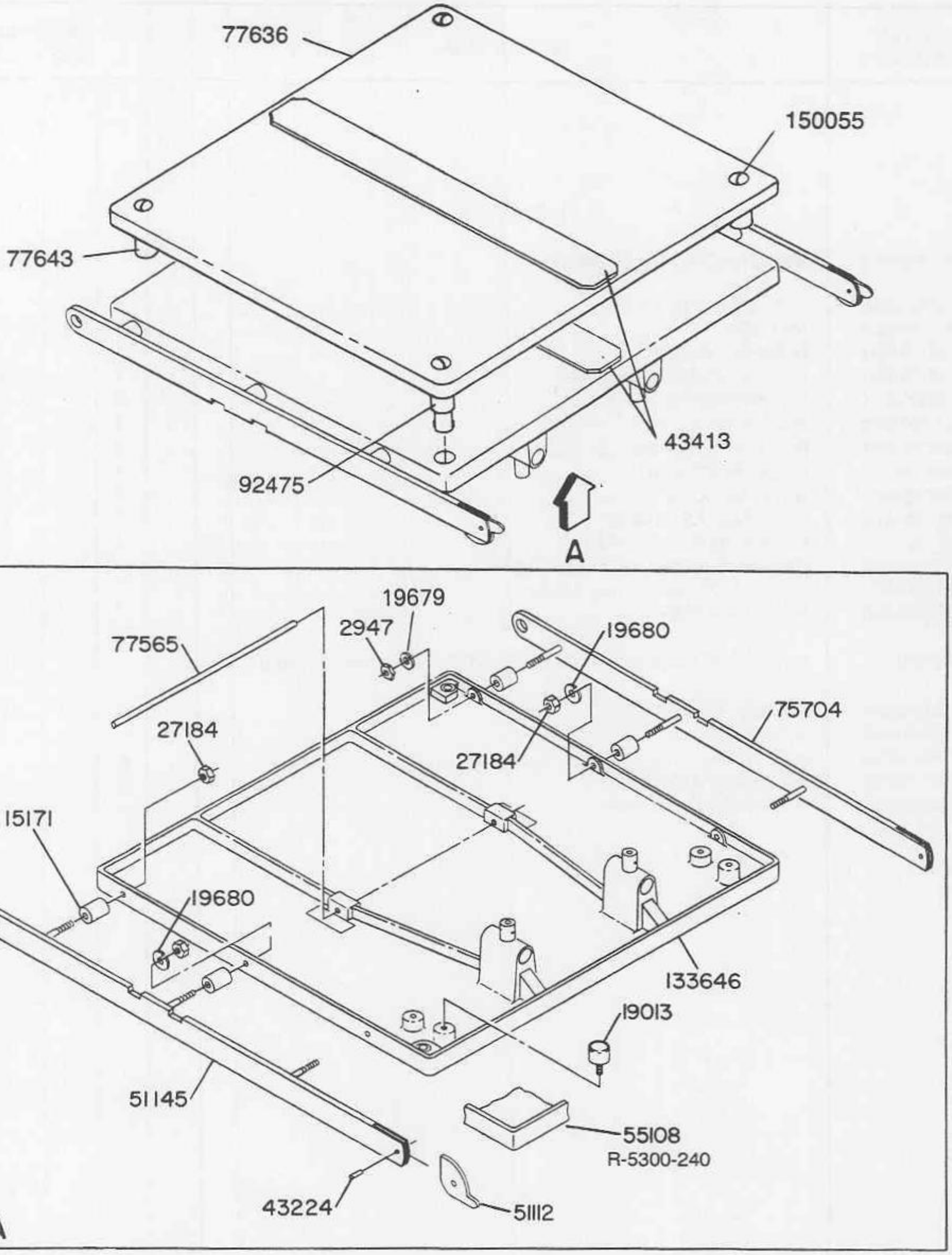
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55108
R-5300-240
43224
51112
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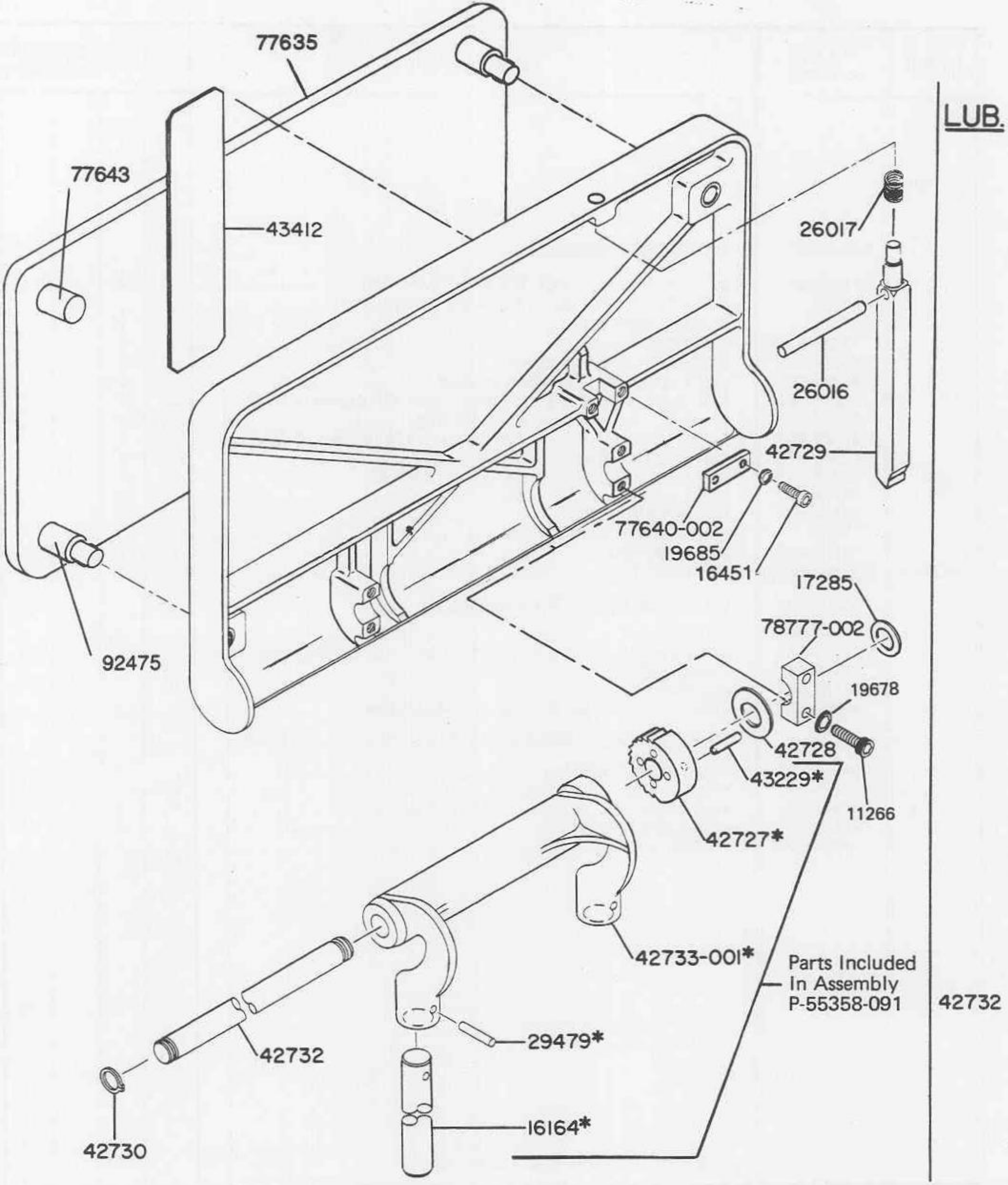
77565

Figure 7-5. BACK SECTION ASSEMBLY (N55105-091)

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-5	
	55105-091	BACK SECTION ASSEMBLY	
	2947-048	NUT, Half, 5/16-18, Steel	1
	15171-042	SPACER	6
	19013-091	BUMPER, Rubber	4
	19679-041	LOCKWASHER, 5/16, Steel	1
	19680-041	LOCKWASHER, 3/8 Steel	2
	27184-045	NUT, Huglock, 5/16-18, Steel	5
	43224-061	PIN, Roll, 3/32 x 3/8 LG., Steel	2
	43413-091	HOOK FASTENER	1
	51112-061	SIDE RAIL CAM	2
	51145-063	SIDE RAIL ASSEMBLY	1
	55108-063	COVER BACK SECTION	1
	75704-063	SIDE RAIL ASSEMBLY, Back Section	1
	77565-061	HINGE ROD BACK, Leg Section	1
	133646-010	BACK SECTION	1
	55125	X-RAY TOP ASSEMBLY, BACK SECTION (Sub: 755715-169)	
	43413-091	• HOOK FASTENER	1
	56397-066	• TOP, X-ray	1
	77643-056	• SPACER	2
	92475-001	• SPACER ASSEMBLY	2
	150055-001	• SCREW, Truss Head	4

Service Bulletin Number						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77640-002
19685
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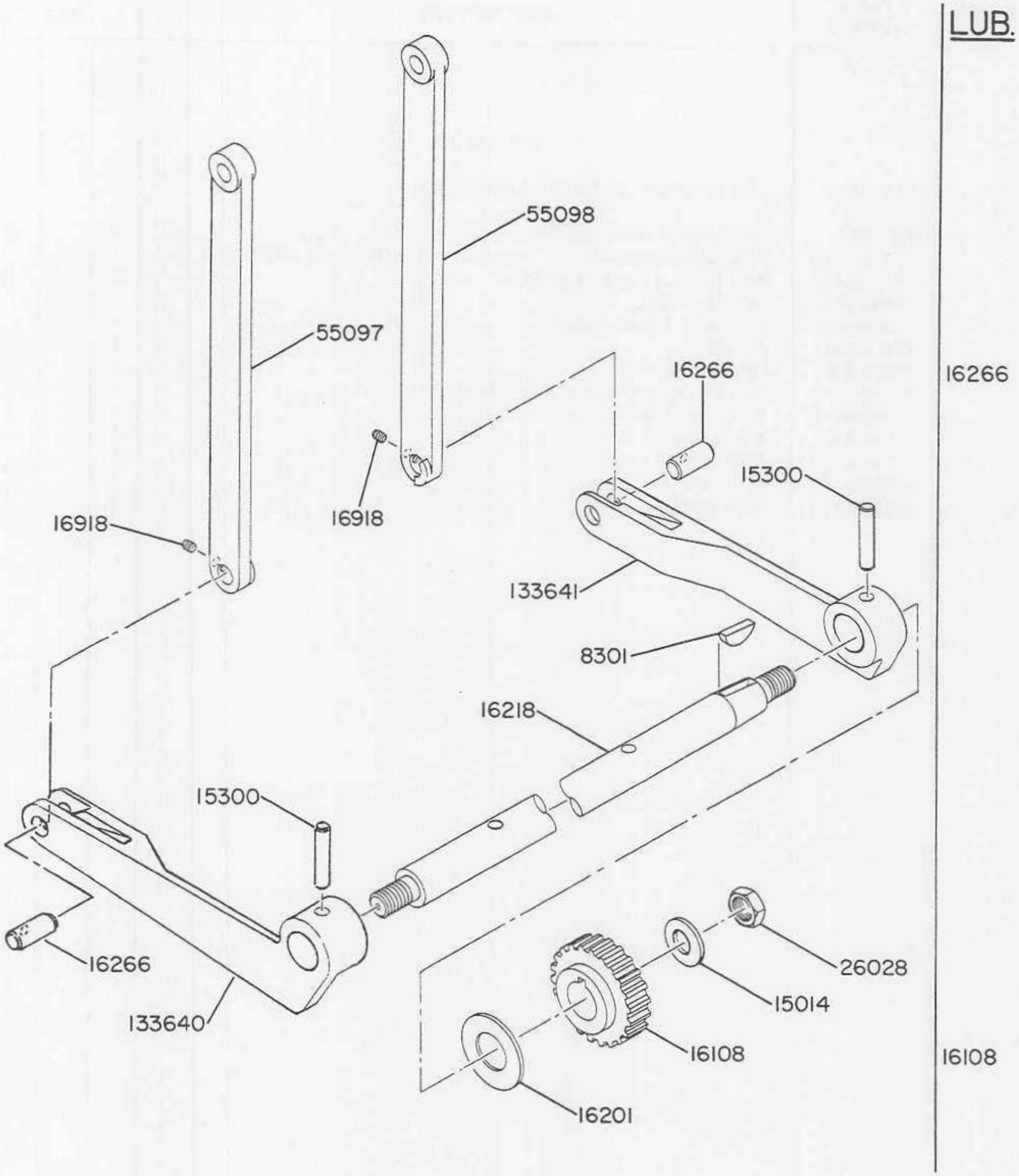
42728
43229*
11266
42727*
42733-001*
Parts Included
In Assembly
P-55358-091
42732
42732
29479*
42730
16164*

Figure 7-6. HEADREST ASSEMBLY (M133688-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-6	
	133688-001	HEADREST ASSEMBLY	
	11266-045	SCREW, Soc. HD. Cap, 1/4-20 x 1" LG., Steel	4
	16451	SCREW, Soc. HD. Cap, 10-32 x 1/2 Nylock, Steel (Sub: 41012-061)	2
	17285-045	WASHER, Special	1
	19678-045	LOCKWASHER, 1/4, Steel	4
	19685-061	LOCKWASHER, 10, Stainless Steel	2
	26016-061	PIN, Grooved, 1/4 x 3" LG., ASA Type "E," Stainless Steel	1
	26017-061	SPRING, Compression, Stainless Steel	1
	42728-042	WASHER, 11/16 I.D. x 1-3/8 O.D. x 1/4 Thickness, Brass	1
	42729-045	RATCHET LEVER	1
	42730-045	RETAINING RING, Waldes Truarc, 5103-62	2
	42732-091	ROD, Hinge	1
	43412-091	HOOK FASTENER	1
	77640	CAP (Sub: 150823-035)	1
	78777-002	BEARING CAP	2
NOTE 1	N.L.A. (99328)	HEADREST	1
	55358-091	SHAFT AND SUPPORT ASSEMBLY	
	16164-044	• SHAFT	2
	29479-061	• PIN, Grooved, 3/16 x 1-1/8 LG., ASA Type "C", Stainless Steel	2
	42727-042	• RATCHET	1
	42733-001	• SUPPORT	1
	43229-061	•PIN, Roll, 3/16 Dia. x 1" LG., Stainless Steel	4
	55124	X-RAY TOP ASSEMBLY, HEAD SECTION (Sub: 755715-168)	
	43412-091	• HOOK FASTENER	1
	56397-067	• TOP, X-ray	1
	77643-056	• SPACER	2
	92475-001	• SPACER ASSEMBLY	2
	150055-001	• SCREW, Truss Head	4
		NOTE 1: Order 133688-001 for headrest 99328.	

Service Bulletin Number						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16108
16108
16201

Figure 7-7. LEG SECTION LEVER ARM ASSEMBLY (N55114-002).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-7	
	55114-002	LEG SECTION LEVER ARM ASSEMBLY	
	8301-091	WOODRUFF KEY, 150, Steel	1
	15014-091	WASHER, .630/.640 I.D. x 1-1/4 O.D. x 1/8 Thickness, Steel	1
	15300-041	PIN, Taper, 6 x 1-3/4 LG., Steel	2
	16108-091	WORM WHEEL	1
	16201-091	WASHER, Thrust, Oilite	1
	16218-061	SHAFT	1
	16266-063	LEVER ARM PIN	2
	16918-041	SCREW, Set, 10-32 x 3/8 LG., Steel	2
	26028-091	NUT, Elastic Stop, 5/16-18, Steel	1
	55097-010	ARM LEVER L.H.	1
	55098-010	ARM LEVER R.H.	1
	133640-010	ARM LEVER	1
	133641-010	ARM LEVER	1

Service Bulletin Number						

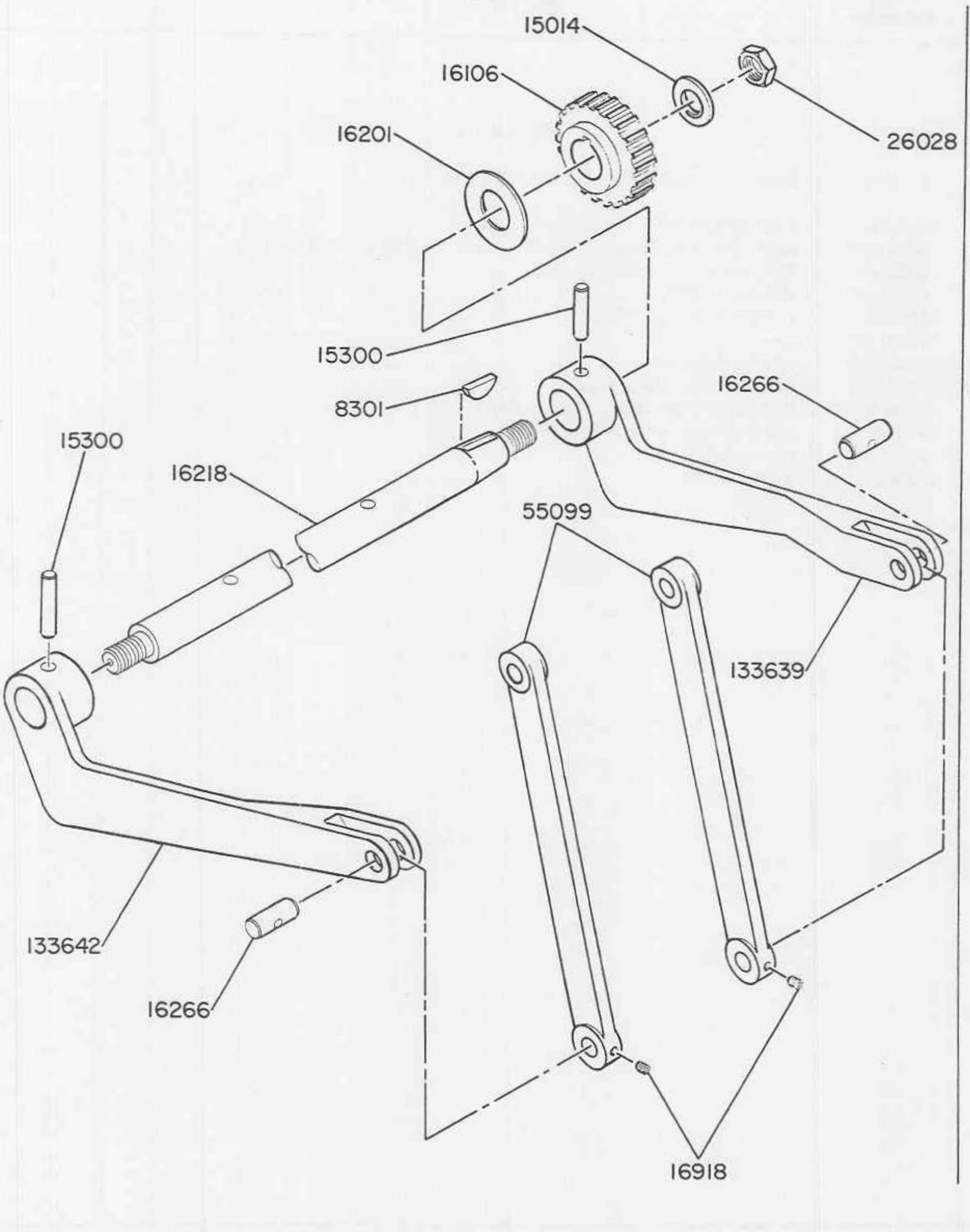
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Figure 7-8. BACK SECTION LEVER ARM ASSEMBLY (N55114-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-8	
	55114-001	BACK SECTION LEVER ARM ASSEMBLY	
	8301-091	WOODRUFF KEY, 150, Steel	1
	15014-091	WASHER, .630/.640 I.D. x 1-1/4 O.D. x 1/8 Thickness, Steel	1
	15300-041	PIN, Taper, 6 x 1-3/4 LG., Steel	2
	16106-091	WORM WHEEL	1
	16201-091	WASHER, Thrust, Oilite	1
	16218-061	SHAFT	1
	16266-063	LEVER ARM PIN	2
	16918-041	SCREW, Set, 10-32 x 3/8 LG., Steel	2
	26028-091	ELASTIC STOP NUT, 5/16-18, Steel	1
	55099-010	ARM LEVER — Back Section	2
	133639-010	ARM LEVER	1
	133642-010	ARM LEVER	1

Service Bulletin Number						

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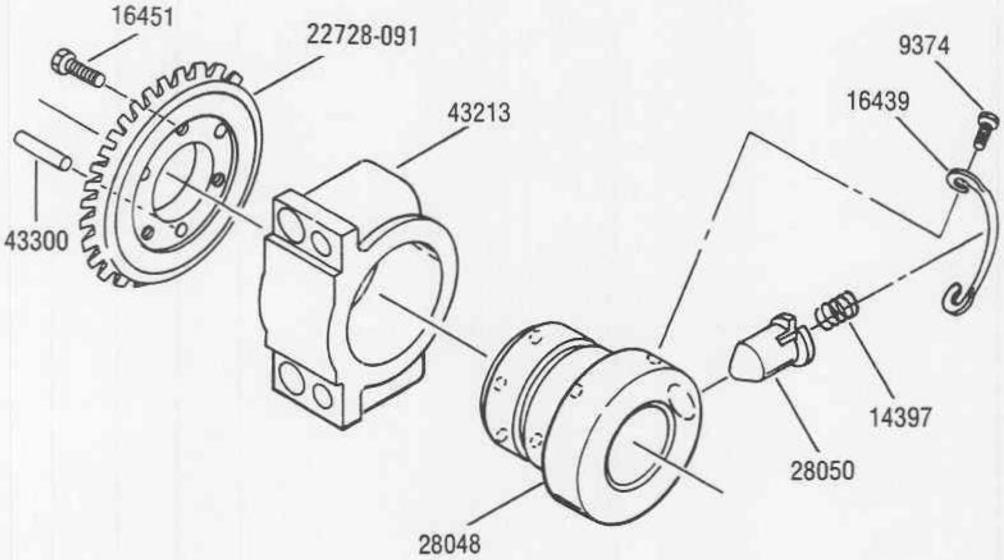
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28050
28048

22728

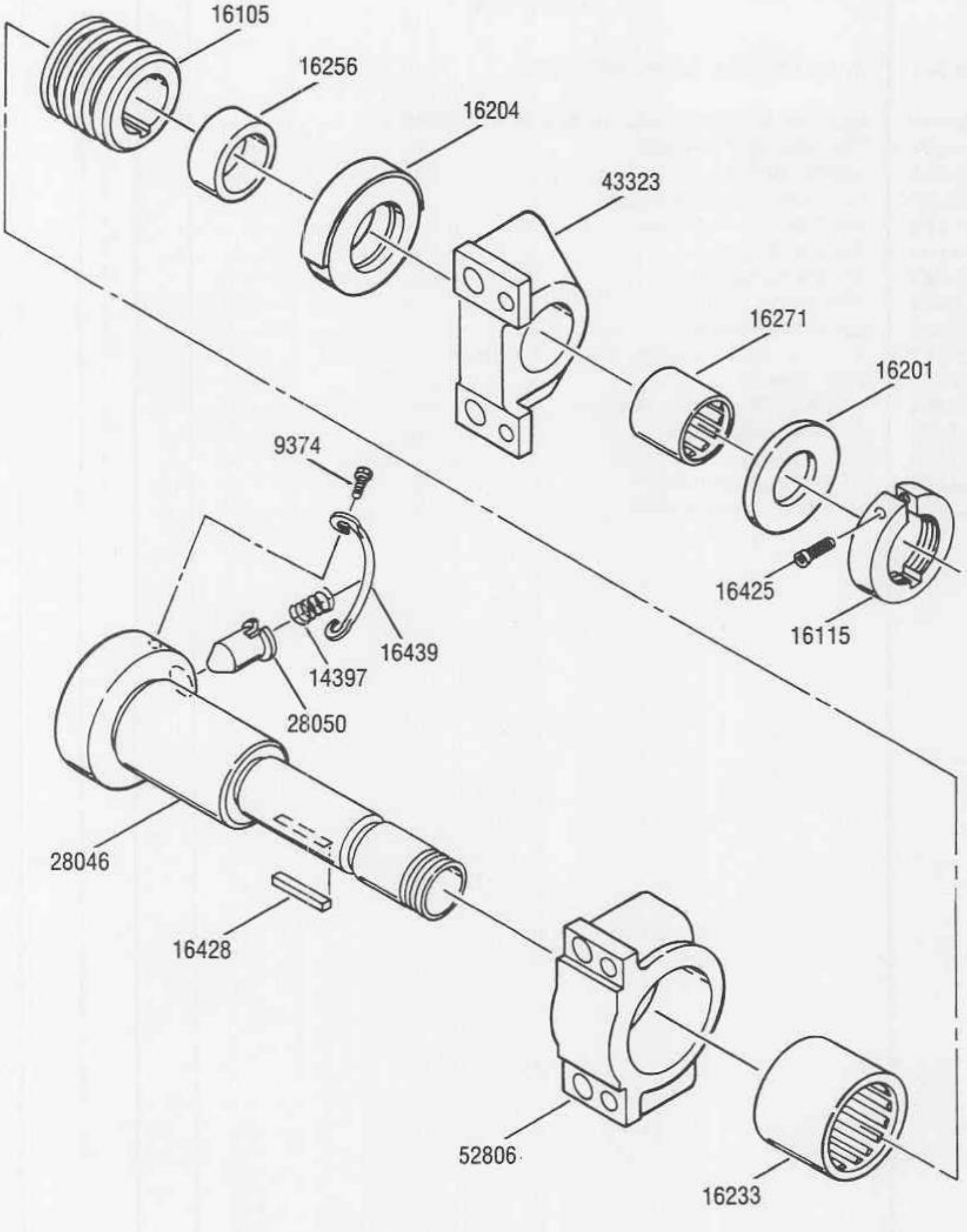
43213

Figure 7-9A. SIDE TILT DRIVE ASSEMBLY (134186-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-9A				
	134186-001	SIDE TILT DRIVE ASSEMBLY				
	9374-041	SCREW, RD. HD. Mach., 10-32 x 3/8 LG., Brass	2			
	14397-091	DRIVING KEY SPRING	1			
NOTE 1	22728-091	DRIVER, Bevel Gear	1			
	16439-091	SPRING, Driving Key Retainer	1			
	16451-042	SCREW, Soc. HD. Cap, 10-32 x 5/8 LG., Brass	3			
	28048-091	DRIVING HEAD	1			
	28050-091	KEY, Driving	1			
	43213-091	BEARING MAIN SHAFT	1			
	43300-061	ROLL PIN, 3/16 x 5/8 LG.	3			
		NOTE 1: Order 22728-091 for gears 16111 (see Fig. 7-2) and 16110.				

Service Bulletin Number						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9374
16425
16115
16439
14397
28050
28046
16428
52806
16233

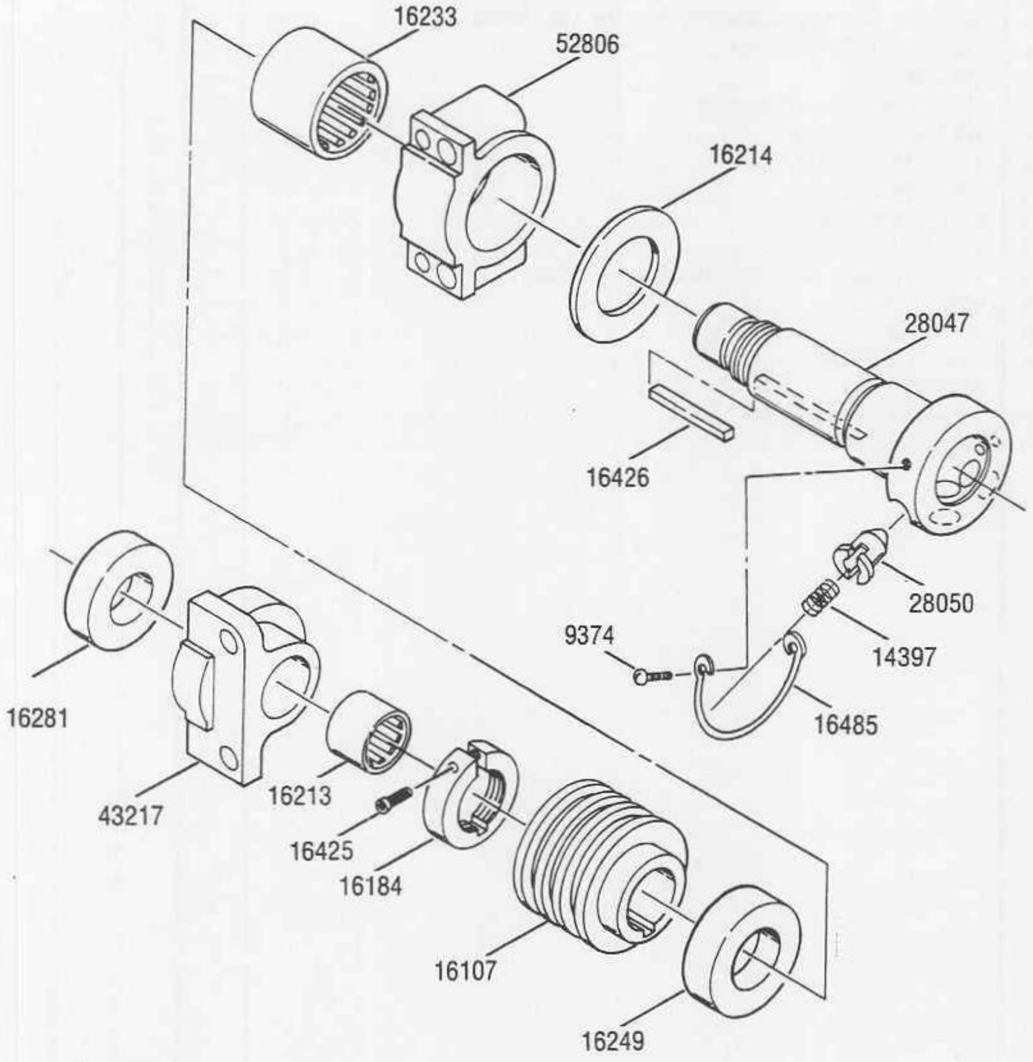
LUB.
16105
16204
43323
16271
52806
16233

Figure 7-9B. BACK SECTION DRIVE ASSEMBLY (134189-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-9B				
	134189-001	BACK SECTION DRIVE ASSEMBLY				
	9374-041	SCREW, RD. HD. Mach., 10-32 x 3/8 LG., Brass	2			
	14397-091	DRIVING KEY SPRING	1			
	16105-091	WORM GEAR	1			
	16115-091	NUT, Drive Head Adjusting	1			
	16201-091	WASHER, Thrust, Oilite	1			
	16204-091	WASHER, Thrust	1			
	16233-091	BEARING, Needle	1			
	16256-091	SPACERS	1			
	16271-091	BEARING, Needle	1			
	16425-041	SCREW, Soc. HD, Cap., 10-32 x 3/4, Brass	1			
	16428-091	KEY, Special	1			
	16439-091	SPRING, Driving Key Retainer	1			
	28046-091	DRIVING HEAD	1			
	28050-091	KEY, Driving	1			
	43323-091	BEARING MAIN SHAFT	1			
	52806-001	BEARING MAIN SHAFT	1			

Service Bulletin Number						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28047
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28050
9374
14397
16485
16281
43217
16213
16425
16184
16107
16249

LUB.

16233
52806

16281

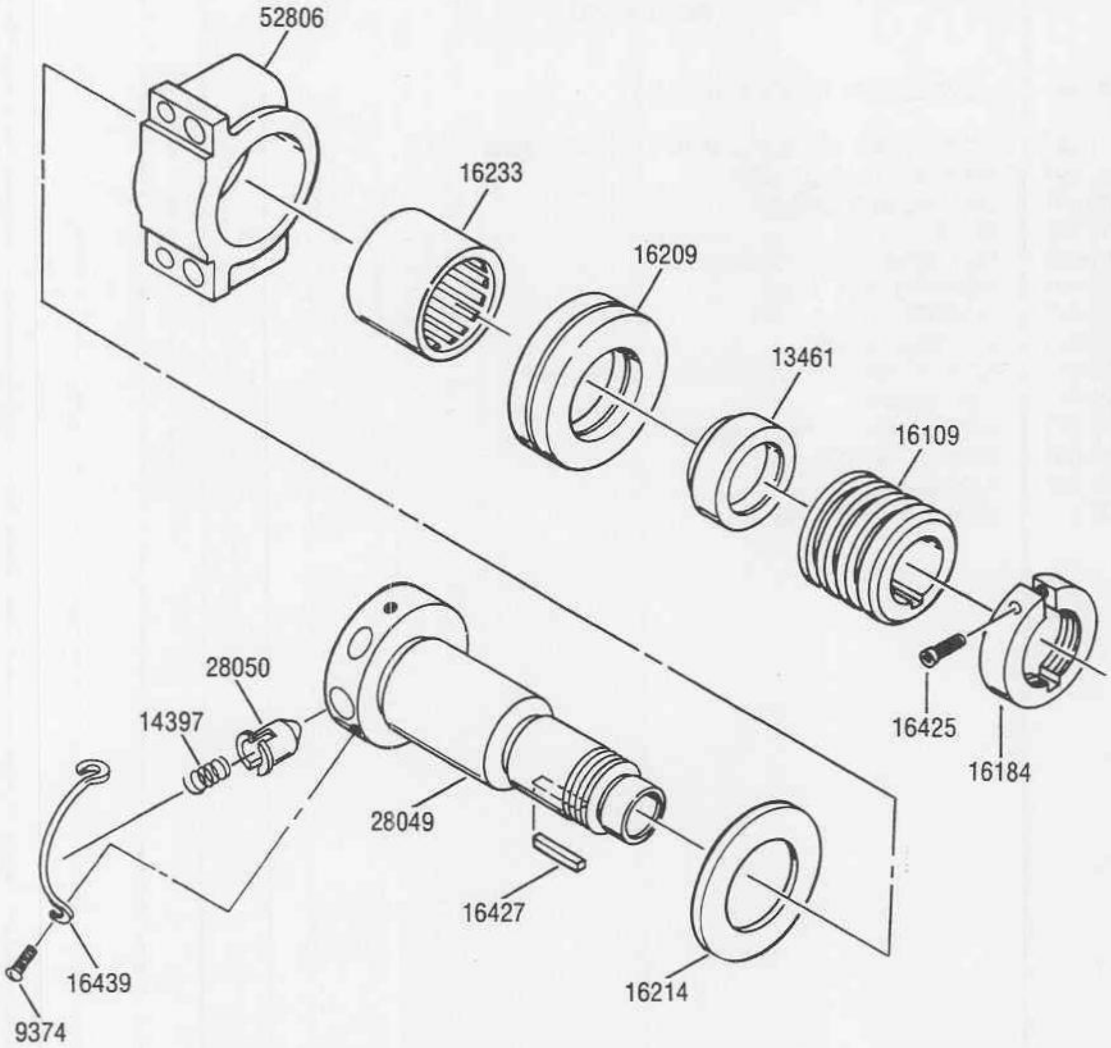
16213
43217

Figure 7-9C. SEAT SECTION DRIVE ASSEMBLY (134188-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-9C				
	134188-001	SEAT SECTION DRIVE ASSEMBLY				
	9374-041	SCREW, RD. HD. Mach., 10-32 x 3/8 LG., Brass	2			
	14397-091	DRIVING KEY SPRING	3			
	16107-091	WORM	1			
	16184-091	NUT, Drive Head Adjusting	1			
	16213-091	BEARING, Needle	1			
	16214-091	WASHER, Thrust, Oilite	1			
	16233-091	BEARING, Needle	1			
	16249-091	BEARING, Thrust	1			
	16281-091	BEARING, Ball	1			
	16425-041	SCREW, Soc. Hd. Cap., 10-32 x 3/4, Brass	1			
	16426-091	KEY, Special	1			
	16485-091	SPRING	1			
	28047-091	DRIVING HEAD	1			
	28050-091	KEY, Driving	3			
	43217-091	BEARING MAIN SHAFT	1			
	52806-001	BEARING MAIN SHAFT	1			

Service Bulletin Number						


52806
16233
16209
13461
16109
28050
14397
28049
16427
16425
16184
16214
16439
9374

LUB.

52806

16209

16109

Figure 7-9D. LEG SECTION DRIVE ASSEMBLY (134187-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-9D	
	134187-001	LEG SECTION DRIVE ASSEMBLY	
	9374-041	SCREW, RD. HD. Mach., 10-32 x 3/8 LG., Brass	2
	13461-091	DRIVING HEAD SPACER	1
	14397-091	DRIVING KEY SPRING	2
	16109-091	WORM	1
	16184-091	NUT, Drive Head Adjusting	1
	16209-091	BEARING, Ball Thrust	1
	16214-091	WASHER, Thrust, Oilite	1
	16233-091	BEARING, Needle	1
	16425-041	SCREW, Soc. HD. Cap., 10-32 x 3/4, Brass	1
	16427-091	KEY, Special	1
	16439-091	SPRING, Driving Key Retainer	1
	28049-091	DRIVING HEAD	1
	28050-091	KEY, Driving	2
	52806-001	BEARING MAIN SHAFT	1

Service Bulletin Number						

LUB.

54611

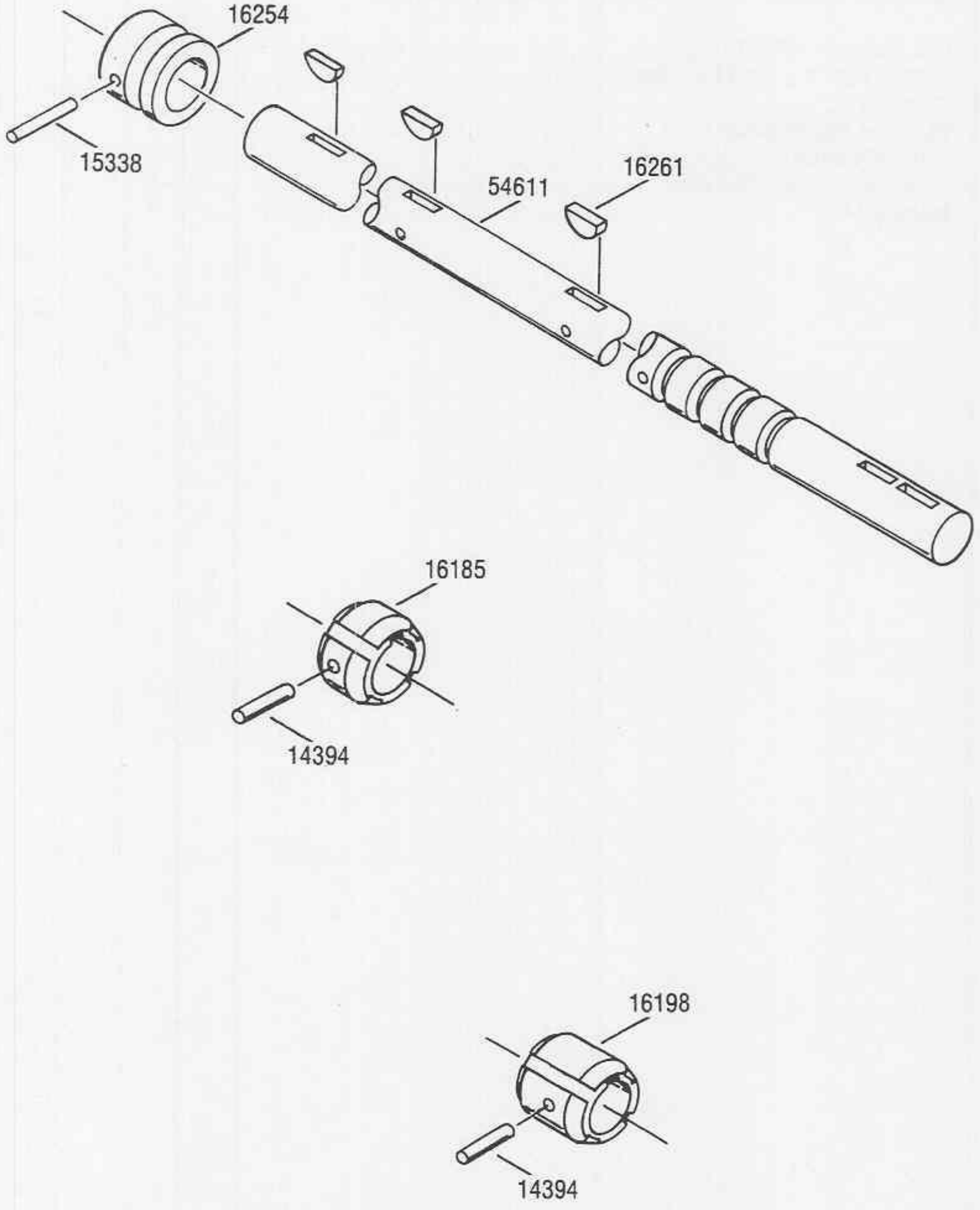
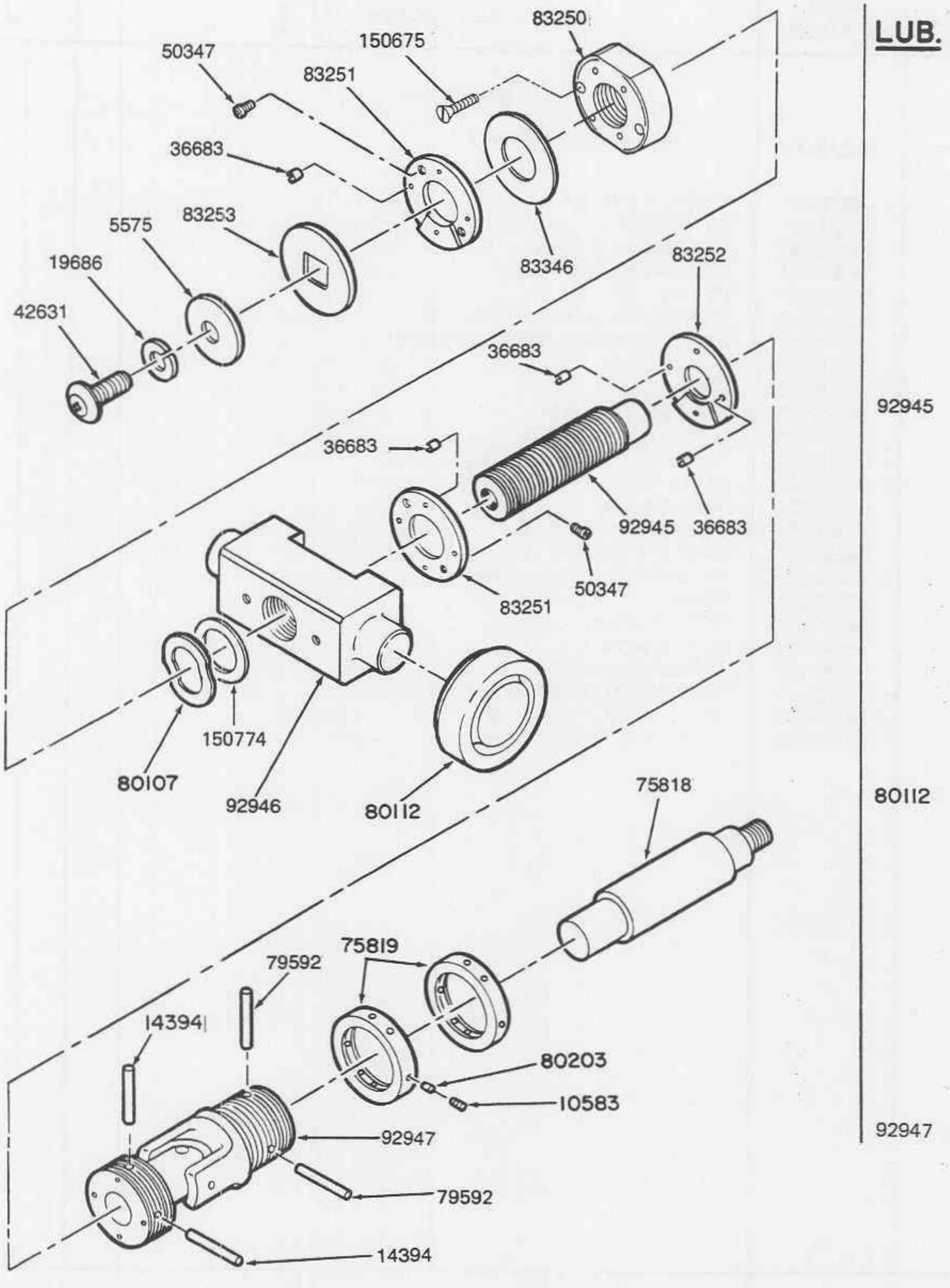

16254
15338
54611
16261
16185
14394
16198
14394

Figure 7-9E. SPECIAL PARTS (150124-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-9E				
	150124-001	SPECIAL PARTS - DRIVE SIDE ASSEMBLY, MANUAL				
	14394-045	PIN, Taper, 3 x 1-1/8	3			
	15338-045	TAPER PIN, 2 x 1-1/4 LG., Steel	1			
	16185-091	CLUTCH	2			
	16198-091	CLUTCH DRIVE SHAFT	1			
	16254-091	SHIFTER SPOOL	1			
	16261-091	WOODRUFF KEY, 90, Steel	5			
	54611-091	MAIN SHAFT	1			

Service Bulletin Number						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36683
5575
83253
19686
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83346
83252
36683
92945
36683
92945
36683
83251
50347
80107
150774
92946
80112
80112
75818
75819
79592
14394
80203
10583
92947
79592
14394
92947

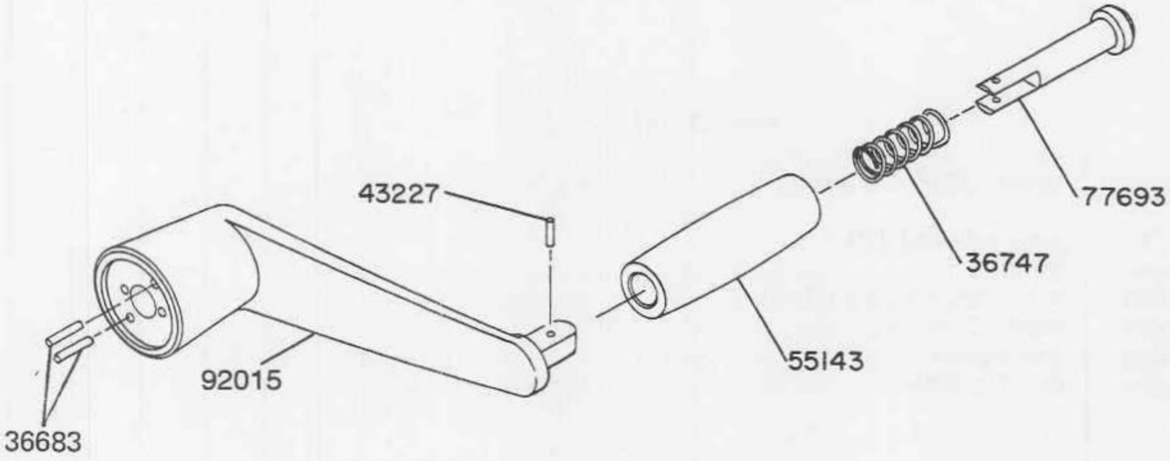
Figure 7-10. SIDE TILT SCREW ASSEMBLY (136210-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-10				
	136210-001	SIDE TILT SCREW ASSEMBLY				
	5575-091	WASHER, Flat, 1/4	1			
	10583-091	SETSCREW	2			
	14394-045	PIN, Taper, 3 x 1-1/8	2			
	19686-061	LOCKWASHER, 1/4	1			
	36683-061	PIN, Roll, 1/8 x 1/2	8			
	42631-045	SCREW, Button Head, 1/4-20 x 1/2	1			
	50347-041	SCREW, Flat Head Socket, 6-32 x 3/8	4			
	75818-091	SHAFT, Drive	1			
	75819-045	NUT	2			
	79592-045	PIN, Taper, 3 x 15/16	2			
	80107-091	WASHER, Spring	1			
	80112-091	BEARING	2			
	80203-091	PLUG, Nylon	2			
	83250-002	NUT, Adjusting	1			
	83251-001	WASHER, Stop, 7/8 I.D.	2			
	83252-001	WASHER, Stop, 5/8 I.D.	1			
	83253-002	WASHER, Stop, Square Hole	1			
	83346-001	SHIM	3			
	92945-001	SCREW, Power	1			
	92946-001	NUT, Side Tilt	1			
	92947-001	UNIVERSAL JOINT	1			
	150675-001	SCREW, Flat Head Socket Cap	2			
	150774-001	SHIM, Side Tilt Screw .036	A/R			
	150774-002	SHIM, Side Tilt Screw .020	A/R			

Service Bulletin Number						

LUB.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77693
36747
55143
92015
36683

77693

55143

Figure 7-11. DRIVE CRANK ASSEMBLY (A92016-001).

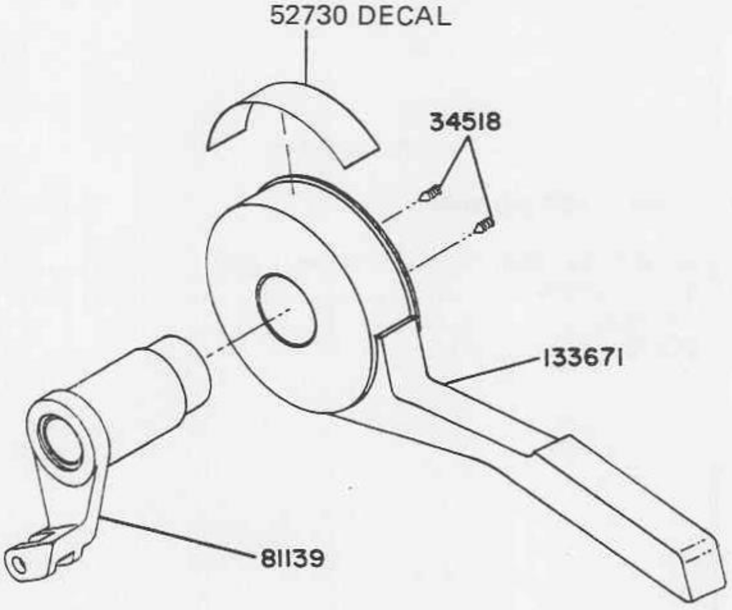

52730 DECAL
34518
133671
81139

Figure 7-12. SHIFT LEVER ASSEMBLY (A55093-091).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-11				
	92016-001	DRIVE CRANK ASSEMBLY				
	36683-061	1/8 x 1/2 ROLL PIN	2			
	36747-091	SPRING	1			
	43227-061	ROLL PIN, 1/8 x 5/8 LG., Steel	1			
	55143-091	HANDLE CRANK	1			
	77693-063	PIN, Handle	1			
	92015-001	DRIVE CRANK	1			
		FIGURE 7-12				
	55093-091	SHIFT LEVER ASSEMBLY				
	34518-061	SCREW, Set Allen Cup Point, Stainless Steel	2			
	81139-091	SHIFT LEVER	1			
	133671-001	HANDLE	1			
	52730-091	DECAL	1			

Service Bulletin Number						

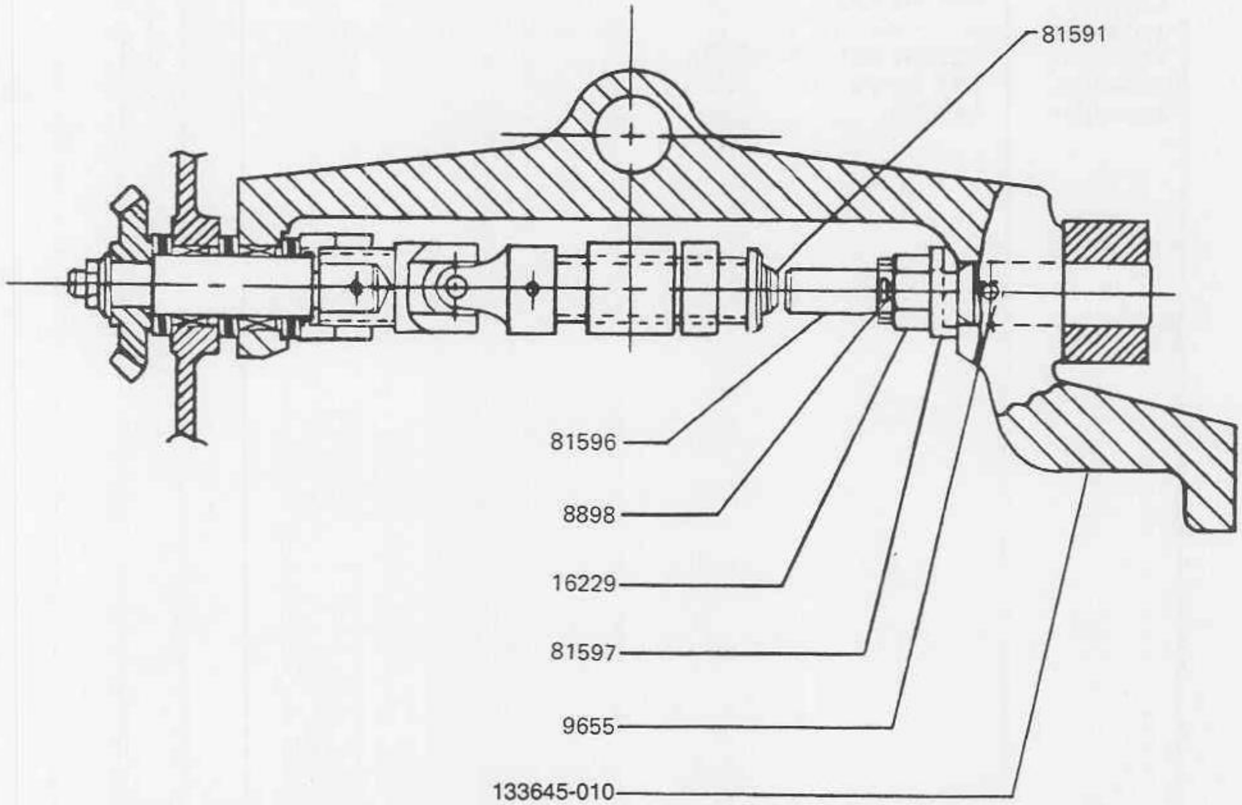
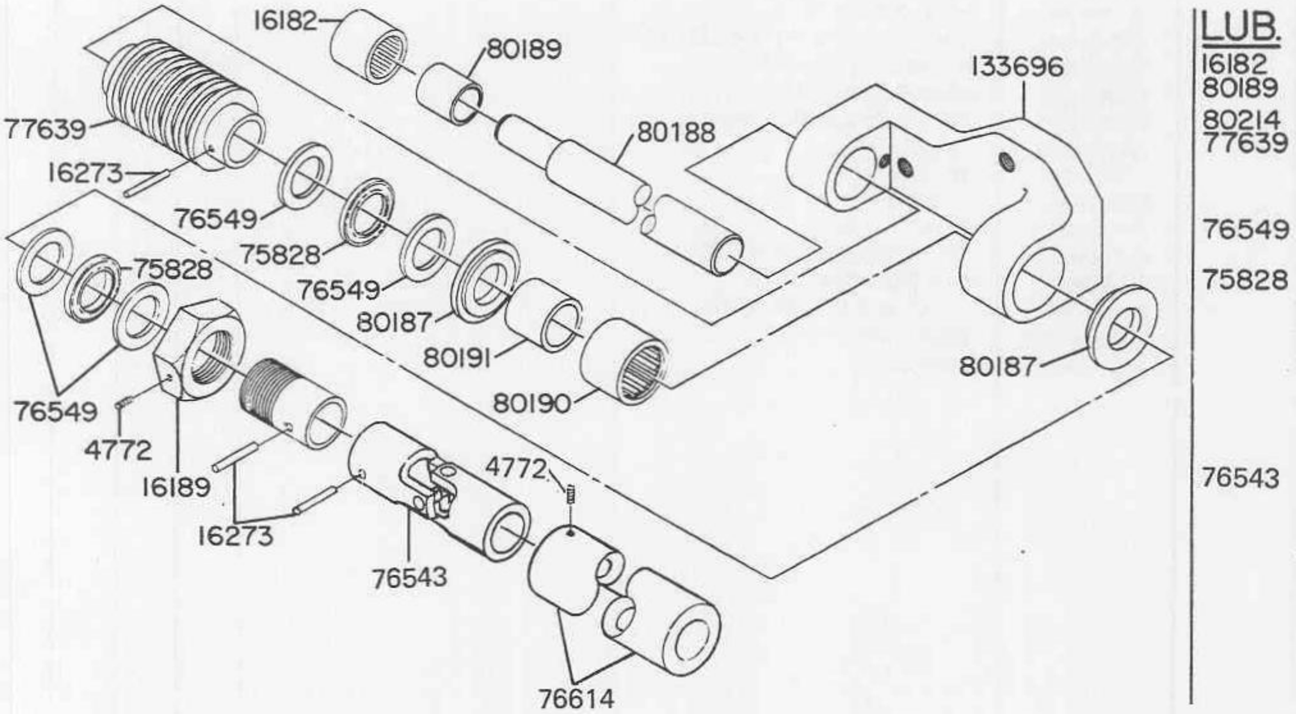

81591
81596
8898
16229
81597
9655
133645-010

Figure 7-13. SIDE TILT SADDLE

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-13				
	133645-010	SIDE TILT SADDLE	1			
	8898-091	PIN, COTTER	1			
	9655-091	SET SCREW	1			
	16229-091	NUT, CASTLE	1			
	81591-001	SCREW, BUTTON HEAD	1			
	81596-001	PIN, SUPPORT	1			
	81597-001	SPACER	1			

Service Bulletin Number						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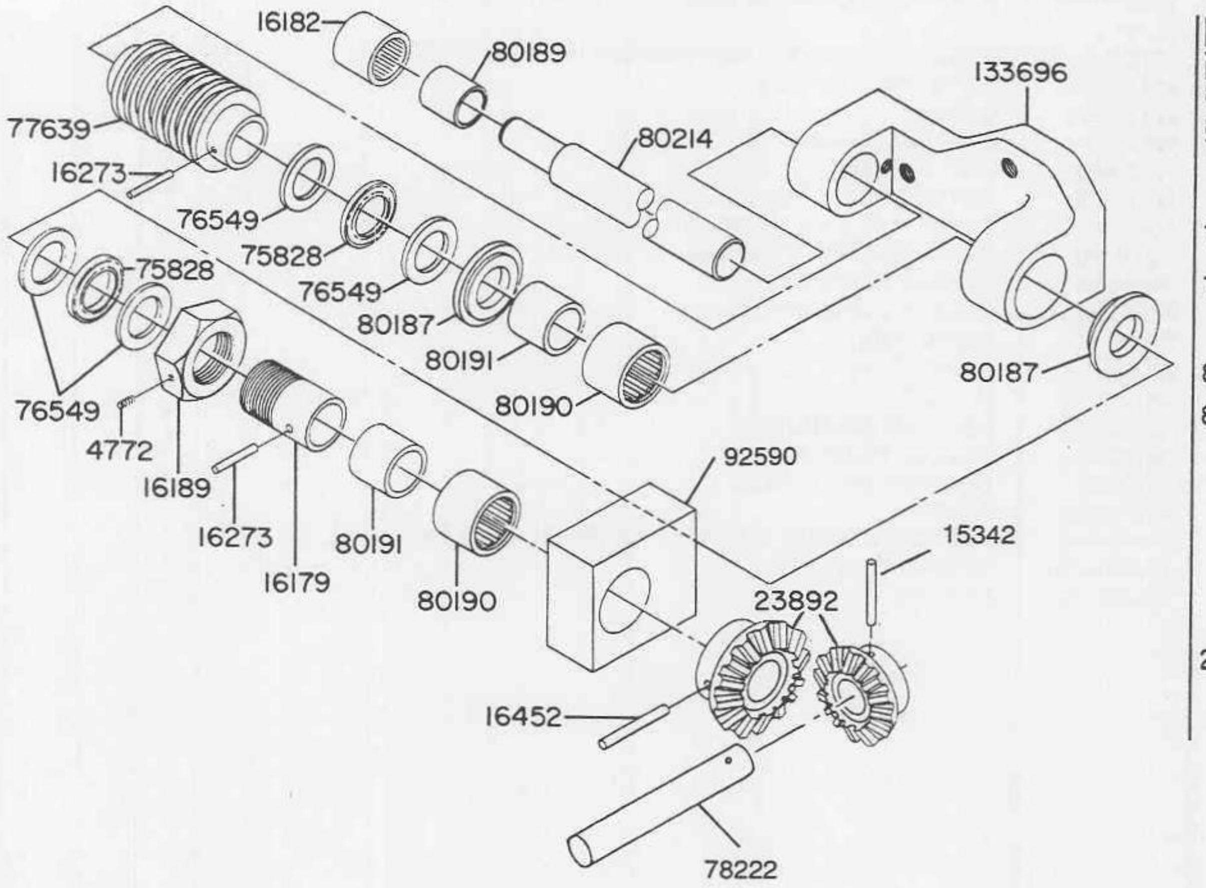
76549
4772
16189
4772
16273
76543
76614
LUB.
16182
80189
80214
77639
76549
75828
76543

Figure 7-14. SHAFT AND BEARING ASSEMBLY (A133676-001); UNITS SHIPPED BEFORE 8/74.

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-14				
	133676-001	SHAFT AND BEARING ASSEMBLY (Units Shipped Before 8/74)				
	4772-045	SCREW, Set Cap Pt., Allen Headless, 1/4-20 x 1/4, Steel	2			
	16179-091	SLEEVE	1			
	16182-091	BEARING, Needle	1			
	16189-091	NUT, Adjusting	1			
	16273-041	TAPER PIN, 5 x 1-1/4 LG., Steel	4			
	75828-091	NEEDLE BEARING	2			
	76543-091	JOINT UNIVERSAL	1			
	76549-091	RACE, Thrust Bearing	4			
	76614-045	SLEEVE	1			
	77639-091	WORM GEAR	1			
	80187-061	SPACER	2			
	80188-091	SHAFT, Trend	1			
	80189-091	BEARING INNER RACE	1			
	80190-091	NEEDLE BEARING	1			
	80191-091	BEARING INNER RACE	1			
	133696-091	GEAR MTG. PLATE	1			
	753975-091	GREASE	A/R			

Service Bulletin Number						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76549
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75828
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80191
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76549
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16189
16273
16179
80191
80190
92590
80187
15342
23892
16452
78222

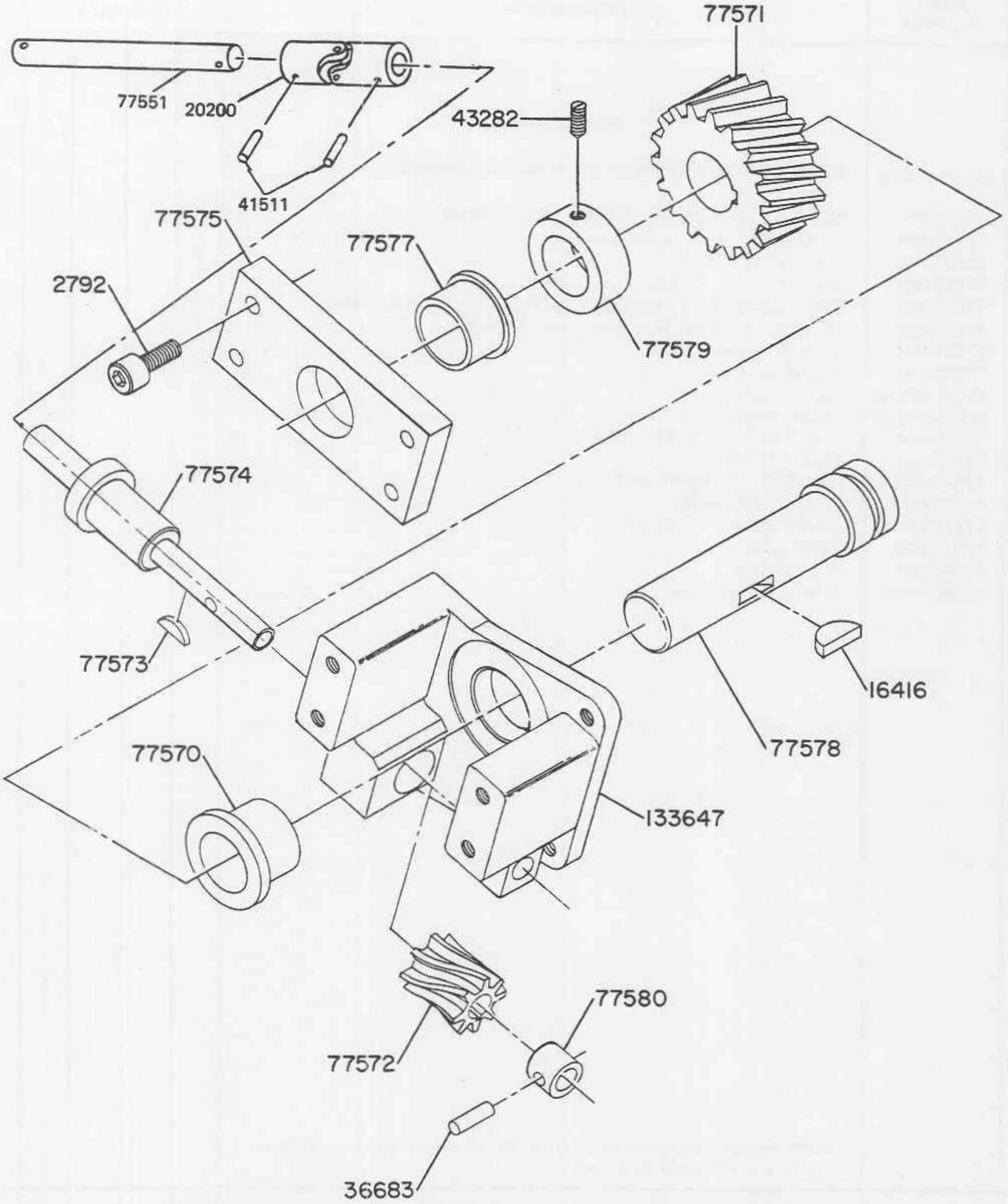
LUB.
16182
80189
80214
77639
76549
75828
80191
80190
23892

Figure 7-14A. SHAFT AND BEARING ASSEMBLY (133676-002); UNITS SHIPPED AFTER 8/74.

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-14A				
	133676-002	SHAFT AND BEARING ASSEMBLY (Units Shipped After 8/74)				
	4772-045	SCREW, Set Cap Pt., Allen Headless, 1/4-20 x 1/4, Steel	1			
	15342-045	TAPER PIN, 3 x 1 LG.	1			
	16179-091	SLEEVE	1			
	16182-091	BEARING, Needle	1			
	16189-091	NUT, Adjusting	1			
	16273-041	TAPER PIN, 5 x 1-1/4 LG., Steel	3			
	16452-041	TAPER PIN, 5 x 1-3/4 LG., Steel	1			
	23892-091	GEAR ASSEMBLY (Includes Both Gears)	1			
	75828-091	NEEDLE BEARING	2			
	76549-091	RACE, Thrust Bearing	4			
	77639-091	WORM GEAR	1			
	78222-061	SHAFT, Drive	1			
	80187-061	SPACER	2			
	80189-091	BEARING INNER RACE	1			
	80190-091	NEEDLE BEARING	2			
	80191-091	BEARING INNER RACE	2			
	80214-091	SHAFT	1			
	92590-001	TRENDELENBURG SUPPORT ASSEMBLY (See Fig. 7-15A)	1			
	133696-091	GEAR MTG. PLATE	1			
	753975-091	GREASE	A/R			

Service Bulletin Number						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77551
20200
43282
41511
77575
77577
2792
77579
77574
77573
16416
77578
77570
133647
77580
77572
36683

Figure 7-15. KIDNEY DRIVE ASSEMBLY (55982-001); UNITS SHIPPED BEFORE 8/74.

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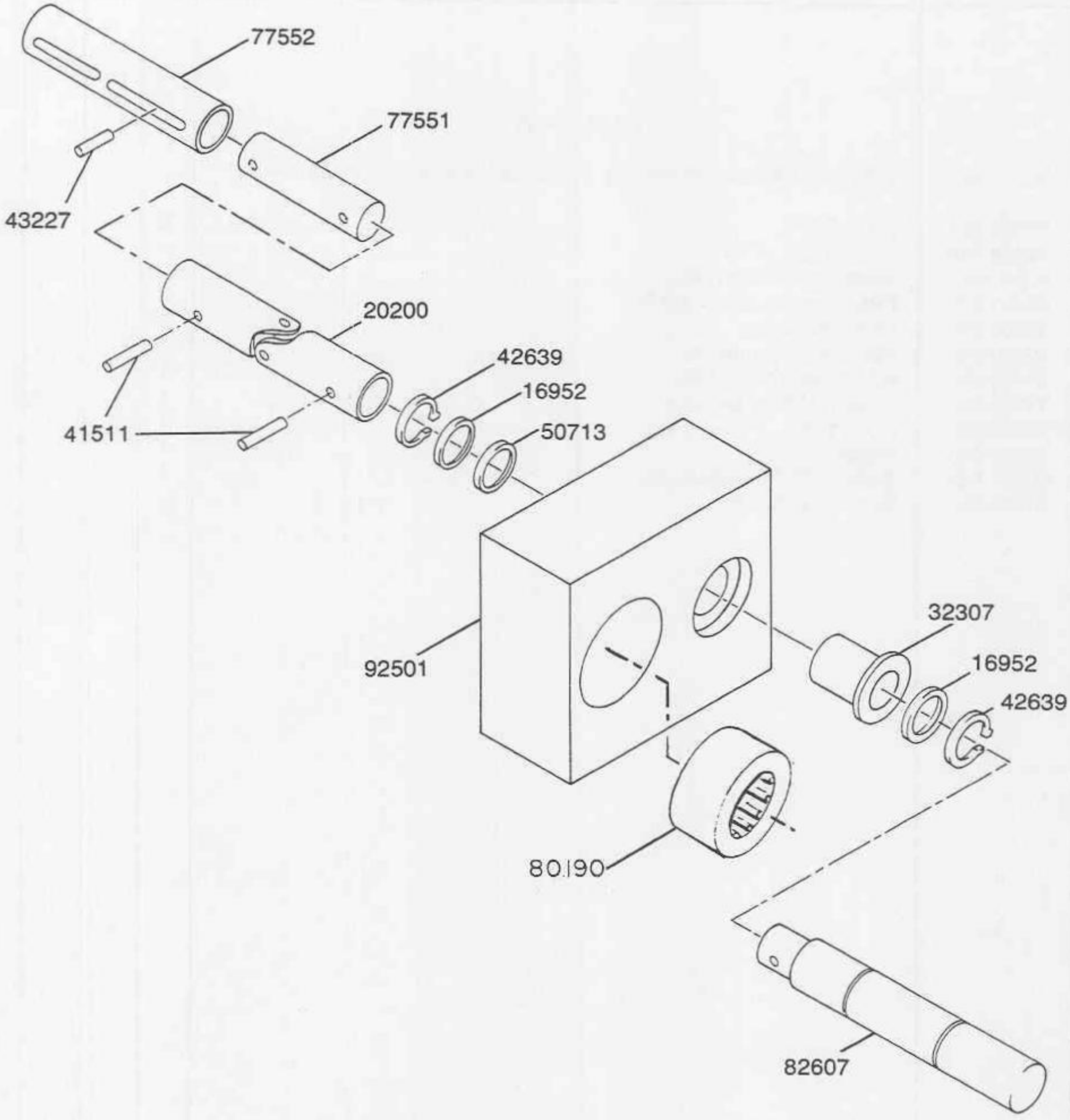
77571
20200
77574
77572

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-15	
NOTE 1	N.L.A.(55982)	KIDNEY DRIVE ASSEMBLY (Units Shipped Before 8/74)	
	2792-045	SCREW, Soc. HD. Cap, 1/4-20 x 1/2 LG., Steel	6
	16416-091	WOODRUFF KEY, 3, Steel	3
	20200-045	UNIVERSAL JOINT	1
	36683-061	PIN, Roll, 1/8 x 1/2 LG.	3
	41511-061	PIN, Grooved, 5/32 x 5/8 LG., ASA Type "C," Stainless Steel	2
	43282-091	SCREW, Cup Point Soc., 10-32 x 5/16, Steel	1
	77551-061	SHAFT, Kidney Elevator	1
	77570-091	BEARING, Flange	1
	N.L.A.(77571)	GEAR, Helical R.H.	1
	N.L.A.(77572)	GEAR, Helical R.H.	1
	77573-091	WOODRUFF KEY, 211, Steel	1
	77574-091	SHAFT PINION	1
	77575-091	BEARING RETAINER CAP	1
	77577-091	FLANGE BEARING	1
	77578-061	DRIVE SHAFT — Kidney	1
	77579-091	STOP RING	1
	77580-091	STOP RING	1
	133647-091	PLATE, MOUNTING	1

NOTE 1: Order Conversion Kit Q-760161-001 to replace ratchet-type kidney bridge drive with crank-type drive.

Service Bulletin Number						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43227
20200
42639
16952
41511
50713
92501
32307
16952
42639
80190
82607

LUB.

50713

32307

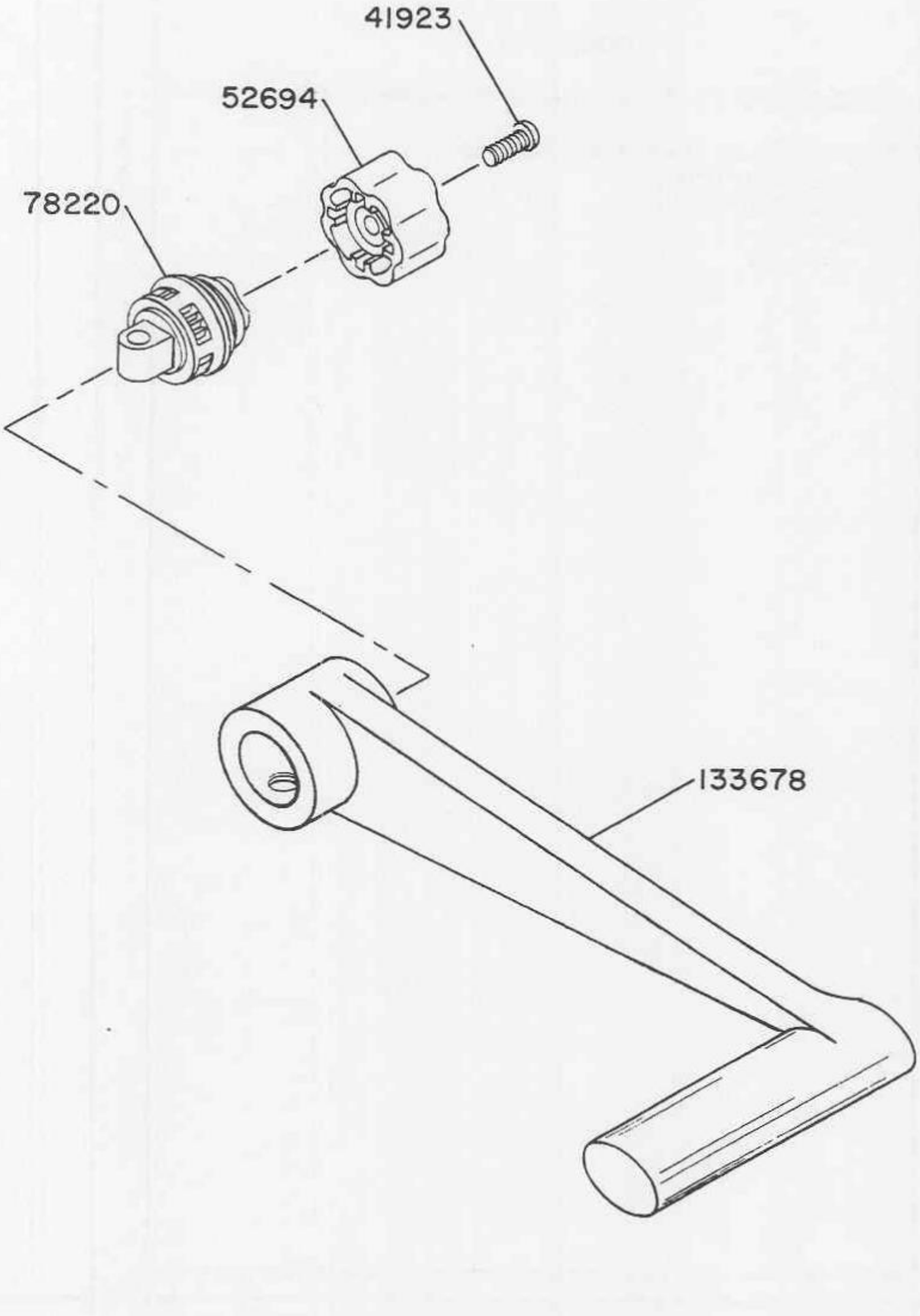
82607

Figure 7-15A. TRENDELENBURG SUPPORT ASSEMBLY (92590-001); UNITS SHIPPED AFTER 8/74.

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-15A	
	92590-001	TRENDELENBURG SUPPORT ASSEMBLY (Units Shipped After 8/74)	
	16952-091	WASHER	2
	20200-045	UNIVERSAL JOINT	1
	32307-091	BEARING, Flange, Oilite	1
	41511-061	PIN, Grooved, 5/32 x 5/8 LG.	2
	42639-091	RING, Retaining	2
	43227-061	PIN, Roll, 1/8 x 5/8 LG.	1
	50713-091	BEARING, Thrust, Oilite	1
	77551-061	SHAFT, Kidney Elevator	1
	77552-061	COUPLING	1
	82607-001	SHAFT, Crank	1
	92501-001	SUPPORT, Trendelenburg	1
	80190-091	BEARING, Needle	1

Service Bulletin Number						


41923
52694
78220
133678

LUB.

78220

Figure 7-16. HANDLE RATCHET ASSEMBLY (A55269-001); UNITS SHIPPED BEFORE 8/74.

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-16				
NOTE 1	55269-001	HANDLE RATCHET ASSEMBLY (Units Shipped Before 8/74)				
	41923-041	SCREW, Oval HD. Mach., 6-32 x 1/2, Brass	1			
	52694-091	RATCHET ADAPTOR	1			
	78220-091	RATCHET INSERT	1			
	133678-056	HANDLE	1			
		NOTE 1: See Figure 7-15 for converting from ratchet-type drive to crank-type drive.				

Service Bulletin Number						

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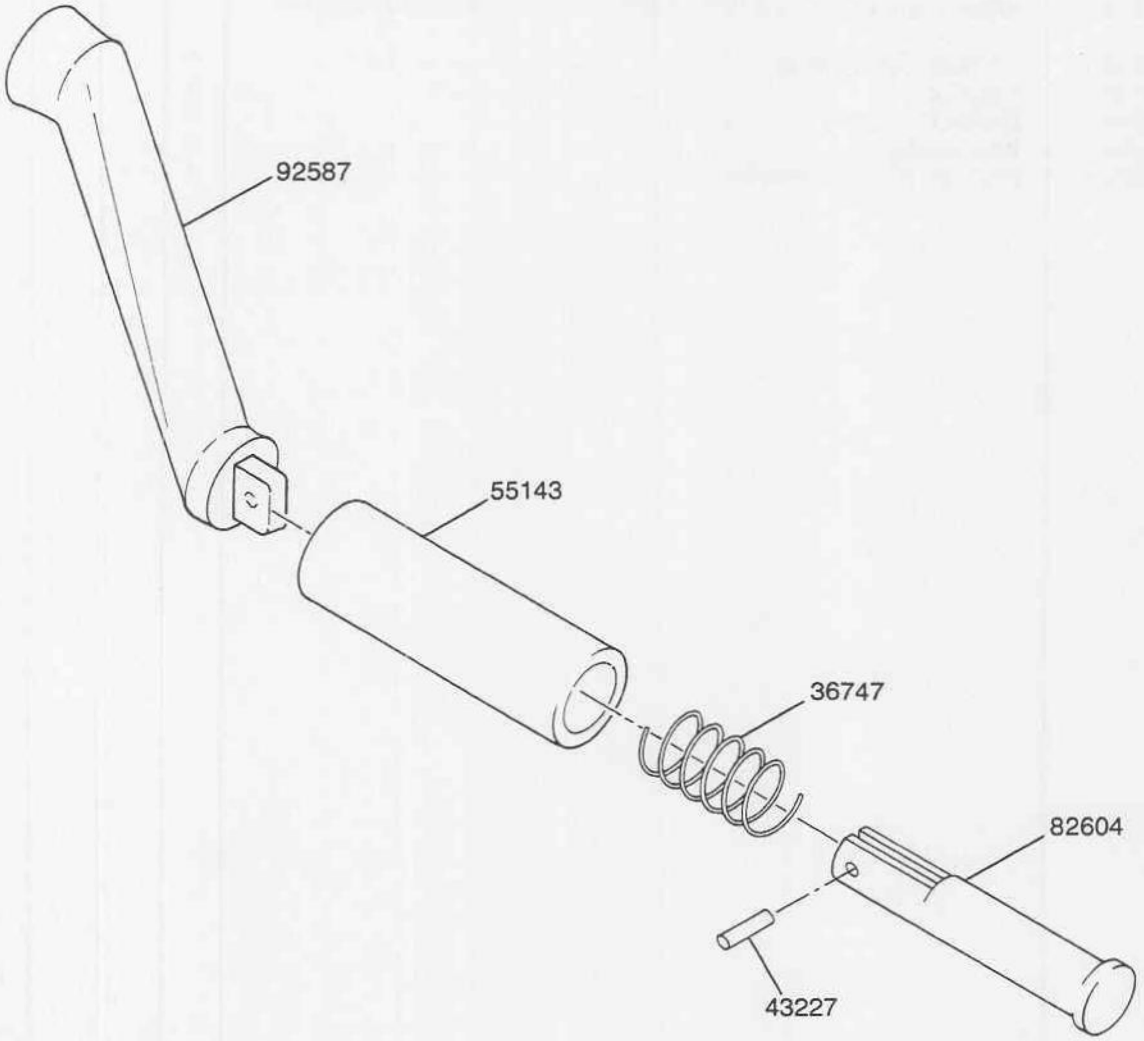

92587
55143
36747
82604
43227

82604

Figure 7-16A. KIDNEY ELEVATOR CRANK ASSEMBLY (92588-001); UNITS SHIPPED AFTER 8/74.

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-16A				
	92588-001	KIDNEY ELEVATOR CRANK ASSEMBLY (Units Shipped After 8/74)				
	36747-091	SPRING, Compression	1			
	43227-061	PIN, Roll	1			
	55143-091	HANDLE, Crank	1			
	82604-001	PIN, Handle	1			
	92587-001	CRANK, Kidney Elevator	1			

Service Bulletin Number						

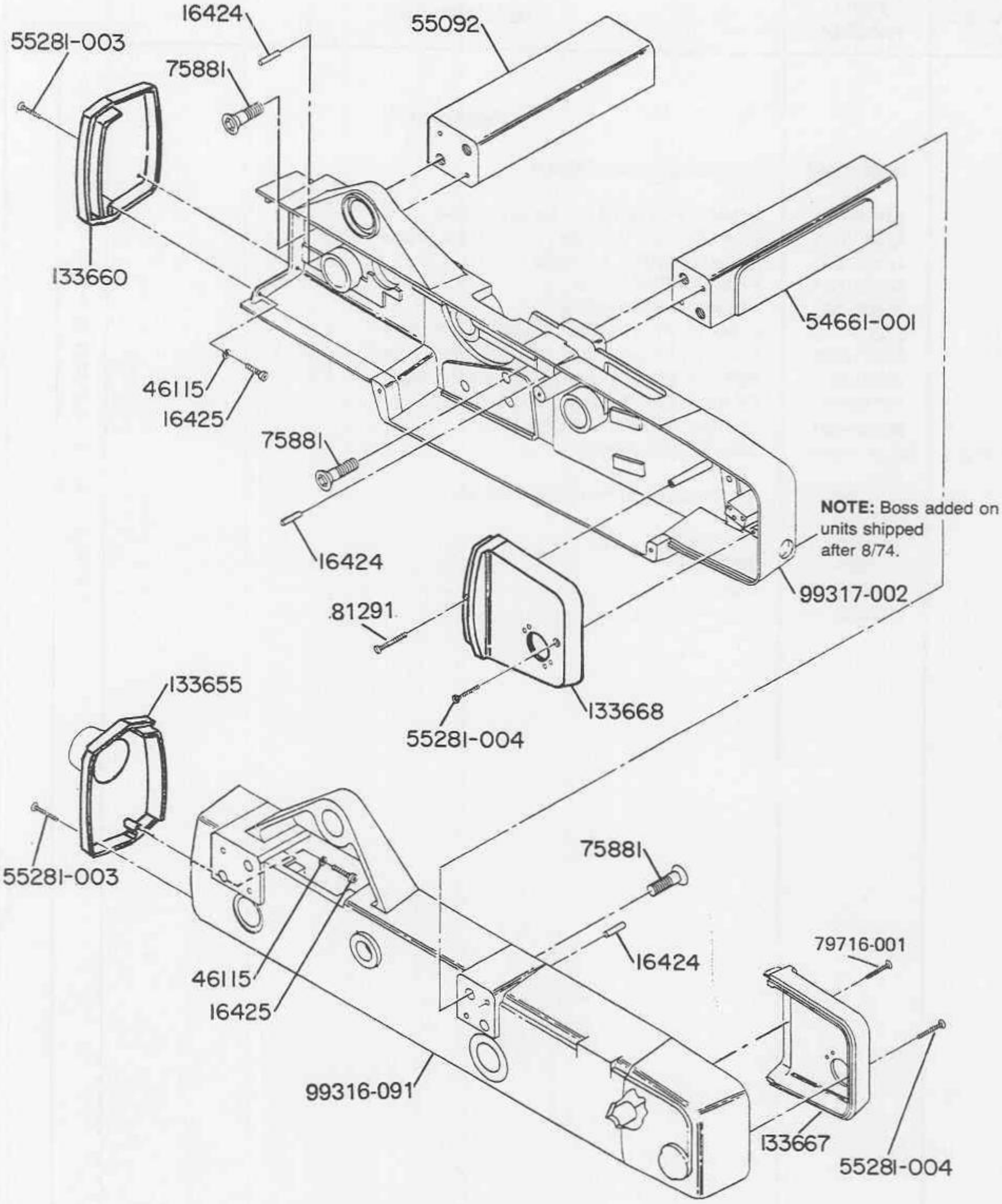
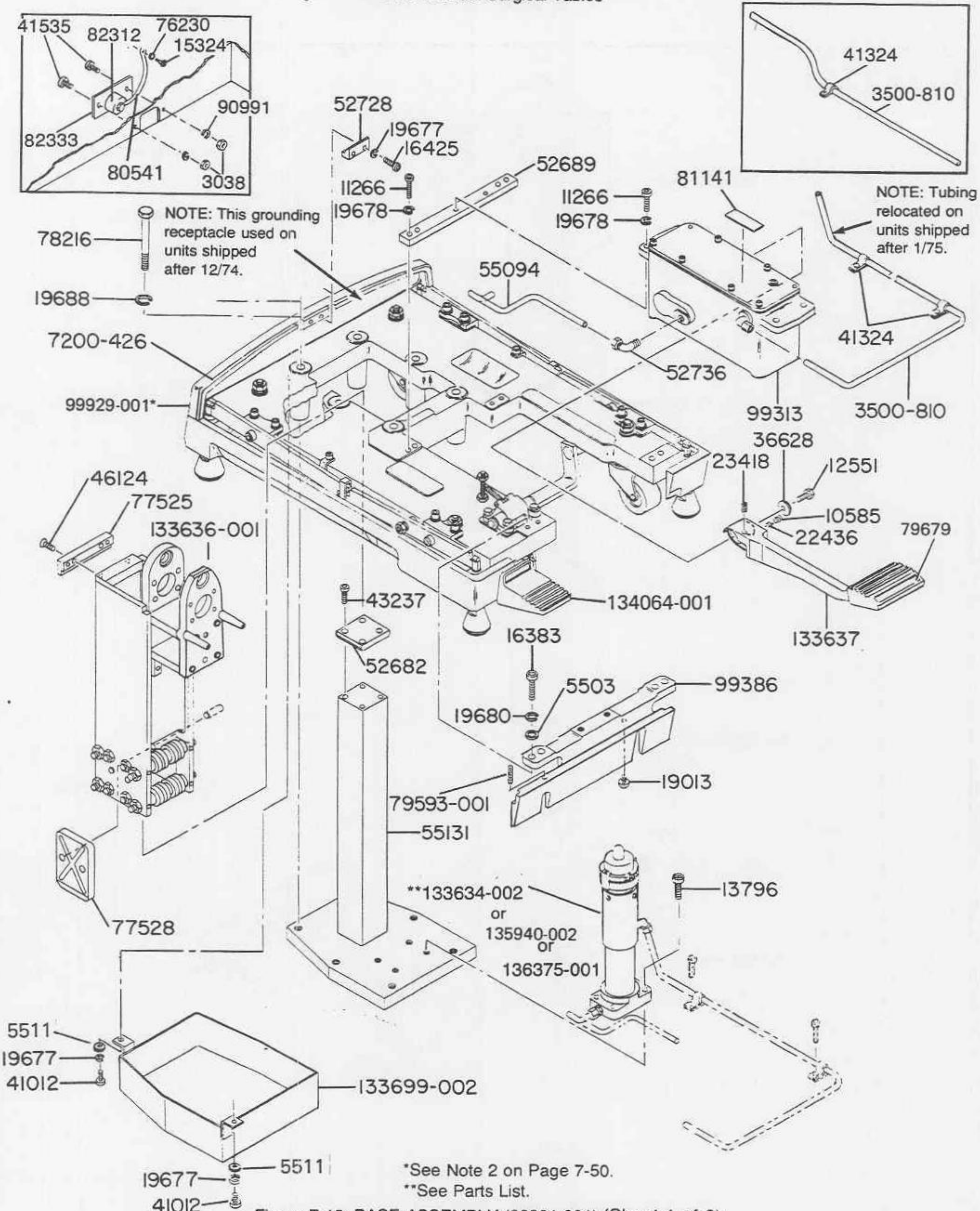

16424
55092
55281-003
75881
133660
54661-001
46115
16425
75881
16424
NOTE: Boss added on units shipped after 8/74.
99317-002
81291
133655
133668
55281-004
55281-003
75881
79716-001
16424
46115
16425
99316-091
133667
55281-004

Figure 7-17. SIDE FRAME ASSEMBLY (134067-004).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-17				
	134067-004	SIDE FRAME ASSEMBLY				
	16424-091	DOWEL PIN, 5/16 x 1-1/4 LG., Steel	14			
	16425-041	SCREW, Soc. HD. Cap, 10-32 x 3/4, Brass	9			
	46115-091	LOCKWASHER, 10, Steel	5			
	54661-001	REAR CROSSPIECE	1			
	55092-091	FRONT CROSSPIECE	1			
	55281-003	SCREW, FT. HD. Soc., 10-32 x 1-1/4, Steel	5			
	55281-004	SCREW, FT. HD. Soc., 10-32 x 1-1/2, Steel	2			
	75881-042	SCREW, FT. HD. Soc., Cap, Nylock, 5/8-11 x 1-3/4, Steel	8			
	79716-001	SCREW, FT. HD. Soc., 10-32 x 4-3/4, Steel	1			
	81291-001	SCREW, FT. HD., 10-32 x 2	1			
NOTE 1	N.L.A.(99316-091)	DRIVE SIDE FRAME	1			
	N.L.A.(99317-002)	TRENDELENBURG SIDE FRAME	1			
	133655-091	END CAP	1			
	133660-091	END CAP	1			
	133667-091	COVER	1			
	133668-091	COVER	1			
		NOTE 1: Special Order Only				

Service Bulletin Number						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79679
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77525
133636-001
43237
134064-001
133637
16383
52682
5503
99386
19680
19013
79593-001
55131
**133634-002
or
135940-002
or
136375-001
13796
77528
5511
19677
41012
133699-002
19677
5511
41012

NOTE: This grounding receptacle used on units shipped after 12/74.

NOTE: Tubing relocated on units shipped after 1/75.

*See Note 2 on Page 7-50.

**See Parts List.

Figure 7-18. BASE ASSEMBLY (99931-001) (Sheet 1 of 2).

Service Bulletin Number						

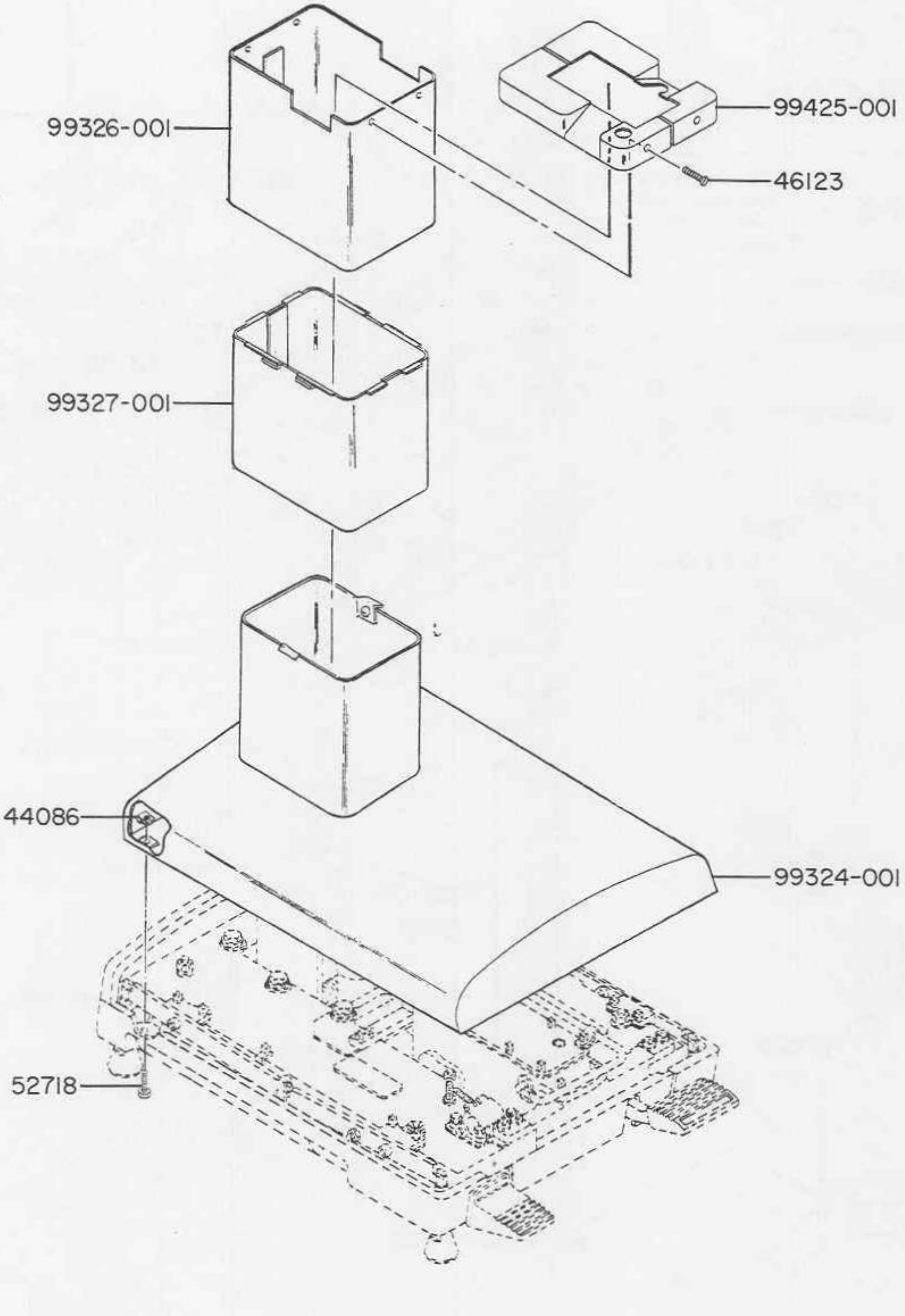

99326-001
99425-001
46123
99327-001
44086
99324-001
52718

Figure 7-18. BASE ASSEMBLY (99931-001) (Sheet 2 of 2).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-18	
	99931-001	BASE ASSEMBLY	
		(Sheet 1 of 2)	
	3038-041	NUT, 8-32 Hex, Brass	2
	R-3500-810	POLYETHYLENE, 3/8" O.D.	1
	5503-045	WASHER, Flat, 13/32 I.D. x 1" O.D. x 1/16 Thickness, Steel	4
	5511-041	WASHER	2
	R-7200-426	VINYL TAPE, Scotch Foam Single Coated Black, 3/8 Wide x 1/8 Thickness	A/R
	10585-041	SCREW, Set, Allen Cup Point, 10-32 x 1/4, Steel	5
	11266-045	SCREW, Soc. HD., Cap, 1/4-20 x 1" LG. Steel	8
	12551-061	SCREW, Hex. HD., Cap, 5/16-18 x 5/8 LG., Monel	1
	15324-042	SCREW, Steel	1
	16383-045	SCREW, Soc. HD., Cap, 3/8-16 x 1" LG., Steel	4
	16425-041	SCREW, Soc. HD., Cap, 10-32 x 3/4, Brass	2
	19013-091	BUMPER, Rubber	1
	19677-041	LOCKWASHER, 10, Steel	6
	19678-045	LOCKWASHER, 1/4, Steel	8
	19680-041	LOCKWASHER, 3/8, Steel	14
	19688-045	LOCKWASHER, 7/16, Steel	6
	22436-091	PLUG	1
	23418-063	SCREW, Pump Pedal, Stainless Steel	1
	36628-051	WASHER, Special	1
	41012-061	SCREW, Soc. HD., Cap, 10-32 x 1/2, Stainless Steel	4
NOTE 1	41324-091	CLIP	1
	41535-010	SCREW, Flat Head	2
	43237-091	SCREW, Button HD. Soc., 3/8-16 x 3/4, Steel	2
	46124-056	SCREW, FT. HD. Soc., 1/4-20 x 3/4, Steel	2
	52682-001	ELEVATOR STOP	1
	52689-010	BRACKET, Sump Mounting	1
	52728-091	SUPPORT COVER	1
	52736-091	ELBOW, Male, 5/16 O.D.T. x 1/4 IPS, Brass	1
	55094-091	TUBING	1
	55131-010	ELEVATOR ASSEMBLY	1
	76230-091	LOCKWASHER	1
	77525-045	SPACER	1
	77528-091	SLIDE BEARING	2
	78216-045	SCREW, Hex. HD., Cap, 7/16-20 x 5", Steel	6
	79593-001	SCREW, Set, Hex Soc. Cup Pt., 1/4-20 x 1/4, Steel	1
	79679-001	NAMEPLATE — RAISE/LOWER	1
	56397-013	LABEL, Oil Spec.	1
	82312-001	GROUNDING RECEPTACLE	1
	119551-091	GROUNDING CABLE	1
	82333-001	BAR, Mounting	1
	90991-091	LOCKWASHER	2
	80541-091	WIRE, Ground Jump	1
	99313-091	PUMP & SUMP ASSEMBLY (See Fig. 7-19)	1
	99386-011	FRONT BASE PLATE	1
	99386-010	FRONT BASE PLATE	1
NOTE 2		FLOOR LOCK ASSEMBLY (See Fig. 7-22)	1
	N.L.A.(133634)	LIFT CYLINDER ASSEMBLY (Units Shipped Before 10/72)	1
	80203-091	PLUG	4

Service Bulletin Number						

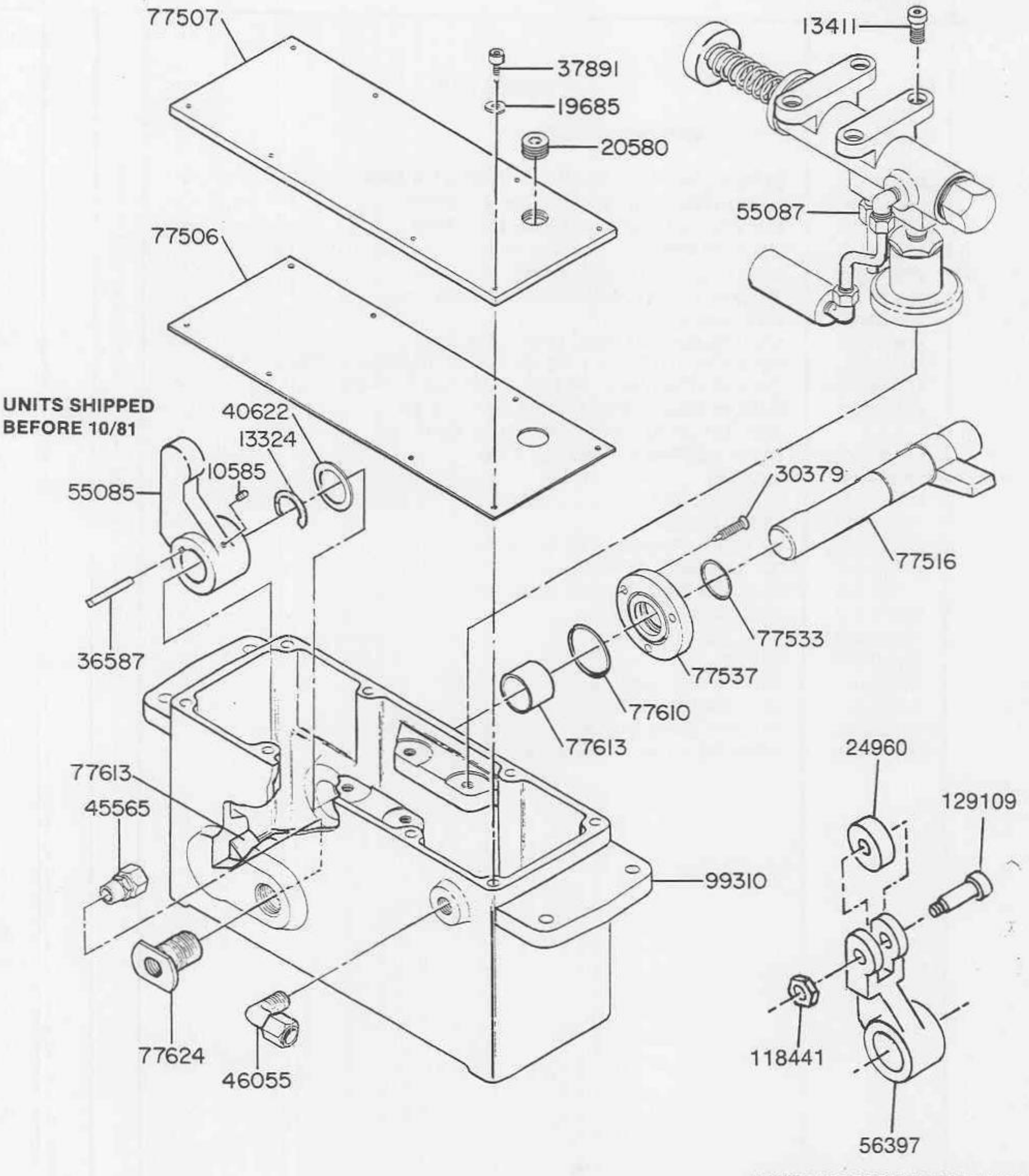
FIGURE 7-18 (Sheet 2 of 2)

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
	133636-001	TABLE SUPPORT ASSEMBLY (See Fig. 7-21)	1			
	133637-010	PEDAL RAISE LOWER	1			
	133699-002	OIL DRIP PAN ASSEMBLY	1			
	135940-002	LIFT CYLINDER ASSEMBLY (Units Shipped Between 10/72 and 11/77)	1			
	136375-001	LIFT CYLINDER ASSEMBLY (Units shipped After 11/77)(See Fig. 7-23)	1			
	134064-001	LIFT CAM ASSEMBLY	1			
	44086-045	SPEED NUT, 'U' Type, 1/4-20, Steel	4			
	46123-010	SCREW, FT. HD. Soc., 10-32 x 1/2, Steel	4			
	52718-091	SCREW, Soc. HD. Cap, 1/4-20 x 2'', Steel	4			
	99324-001	TOP COVER ASSEMBLY	1			
	99326-001	SHROUD UPPER	1			
	99327-001	SHROUD INTERMEDIATE	1			
	99425-001	TOP COVER	1			
	141172-001	BASE	1			

NOTE 1: Two clips used on units shipped before 1/75; one clip on units shipped after 1/75.

NOTE 2: 99929-001 used on units shipped before 1/75. 99929-001 deleted and parts transferred to 99931-001 and 150128-001 on units shipped after 1/75.

Service Bulletin Number						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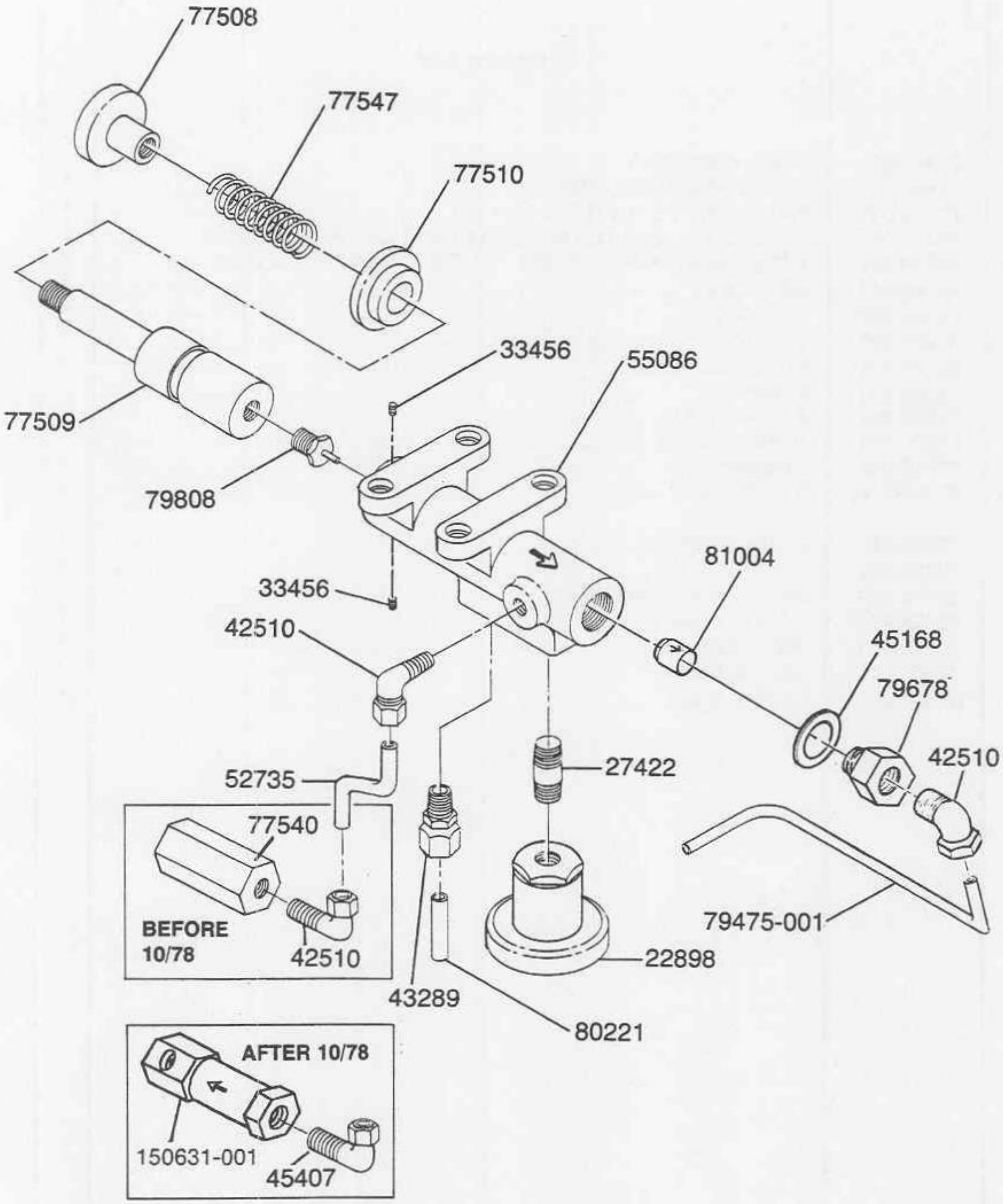
36587
77533
77537
77610
77613
24960
77613
45565
129109
99310
118441
77624
46055
56397
UNITS SHIPPED AFTER 10/81

Figure 7-19. PUMP AND SUMP ASSEMBLY (A99313-091)

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-19	
	99313-091	PUMP AND SUMP ASSEMBLY	
	10585-041	SCREW, Set, Allen Cup Point, 10-32 x 1/4, Steel	1
	13324-091	RETAINING RING, Waldes Truarc, 5103-87	1
	13411-091	SCREW, Soc. HD. Cap, 1/4-20 x 5/8, Steel	4
	19685-061	LOCKWASHER 10, Stainless Steel	8
	20580-042	PIPE PLUG — 1/4 NPT, Brass	1
	30379-041	SCREW, FT. HD., 8-32 x 5/8 LG., Brass	3
	36587-091	KEY, Special Square	1
	37891-041	SCREW, Soc. HD. Cap, 10-24 x 5/8, Steel	8
	40622-061	WASHER, 1-1/4 O.D. x 7/8 I.D. x 3/16 Thickness, Stainless Steel	1
	45565-091	CONNECTOR, Male, 1/4 I.P.S. x 1/4 O.D.T., Brass	1
	46055-091	ELBOW, Male, 1/4 I.P.S. x 3/8 O.D.T., Brass	1
		ACTUATOR (Units Shipped Before 10/81)	1
	55087-001	PUMP ASSEMBLY (See Fig. 7-20)	1
	77506-091	GASKET	1
	77507-010	SUMP COVER	1
	77516-091	PUMP LEVER	1
	77533-091	'O' RING, Precision, 118, Neoprene	1
	77537-045	'O' RING CAP, Steel	1
	77610-091	'O' RING, Precision, 026, Neoprene	1
	77613-091	SLEEVE BEARING	2
	77624-031	SPECIAL FITTING	1
	99310-091	SUMP	1
	56397-012	ACTUATOR (Units Shipped After 10/81)	1
	24960-091	BEARING (Units Shipped After 10/81)	1
	129109-001	SCREW, Shoulder (Units Shipped After 10/81)	1
	118441-045	LOCKNUT, Hex (Units Shipped After 10/81)	1

Service Bulletin Number						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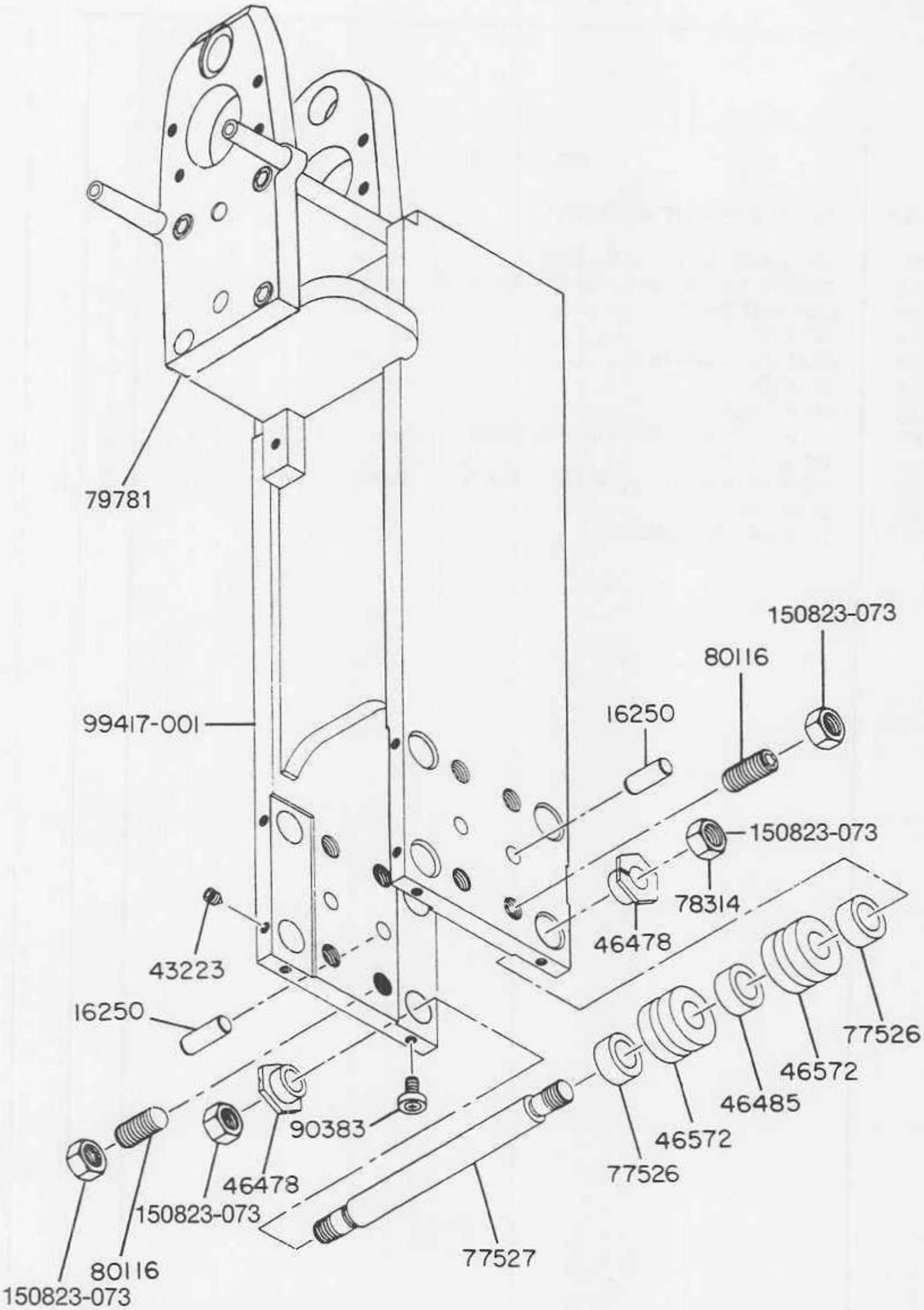
77540
BEFORE 10/78
42510
43289
22898
79475-001
80221
AFTER 10/78
150631-001
45407

Figure 7-20. PUMP ASSEMBLY (N55087-091).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		FIGURE 7-20				
	55087-001	PUMP ASSEMBLY				
	22898-091	VALVE ASSEMBLY, Intake	1			
	27422-091	BRASS NIPPLE, 1/4 NPT x 1-1/4 LG.	1			
	33456-061	SCREW, Set, Allen Cup Point, 8-32 x 3/16 LG., Stainless Steel	2			
NOTE 1	42510-091	COMPRESSION FITTING ELL, 1/4 O.D.T. x 1/8 M.P.T., Brass	2			
	43289-091	COUPLING	1			
	45168-091	"O"-RING	1			
NOTE 1	45407-091	ELBOW	1			
	52735-091	TUBE	1			
	55086-091	PUMP	1			
	77508-091	END PISTON	1			
	77509-091	PUMP PISTON	1			
	77510-091	BUSHING	1			
NOTE 1	77540-NLA	VALVE, Relief	1			
	77547-091	PUMP SPRING	1			
	79475-001	TUBE	1			
	79678-001	NUT, Check Valve Retainer	1			
	79808-001	VALVE, Release	1			
	80221-091	RETURN TUBE	1			
	56397-051	VALVE, Check	1			
NOTE 1	150631-001	VALVE, Relief	1			
		NOTE 1: When replacing Relief Valve 77540, also remove ell 42510 and replace with relief valve 150631-001 and ell 45407-091.				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80116
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150823-073
78314
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43223
16250
77526
46572
46485
46572
77526
90383
46478
150823-073
80116
150823-073
77527

LUB.

77527

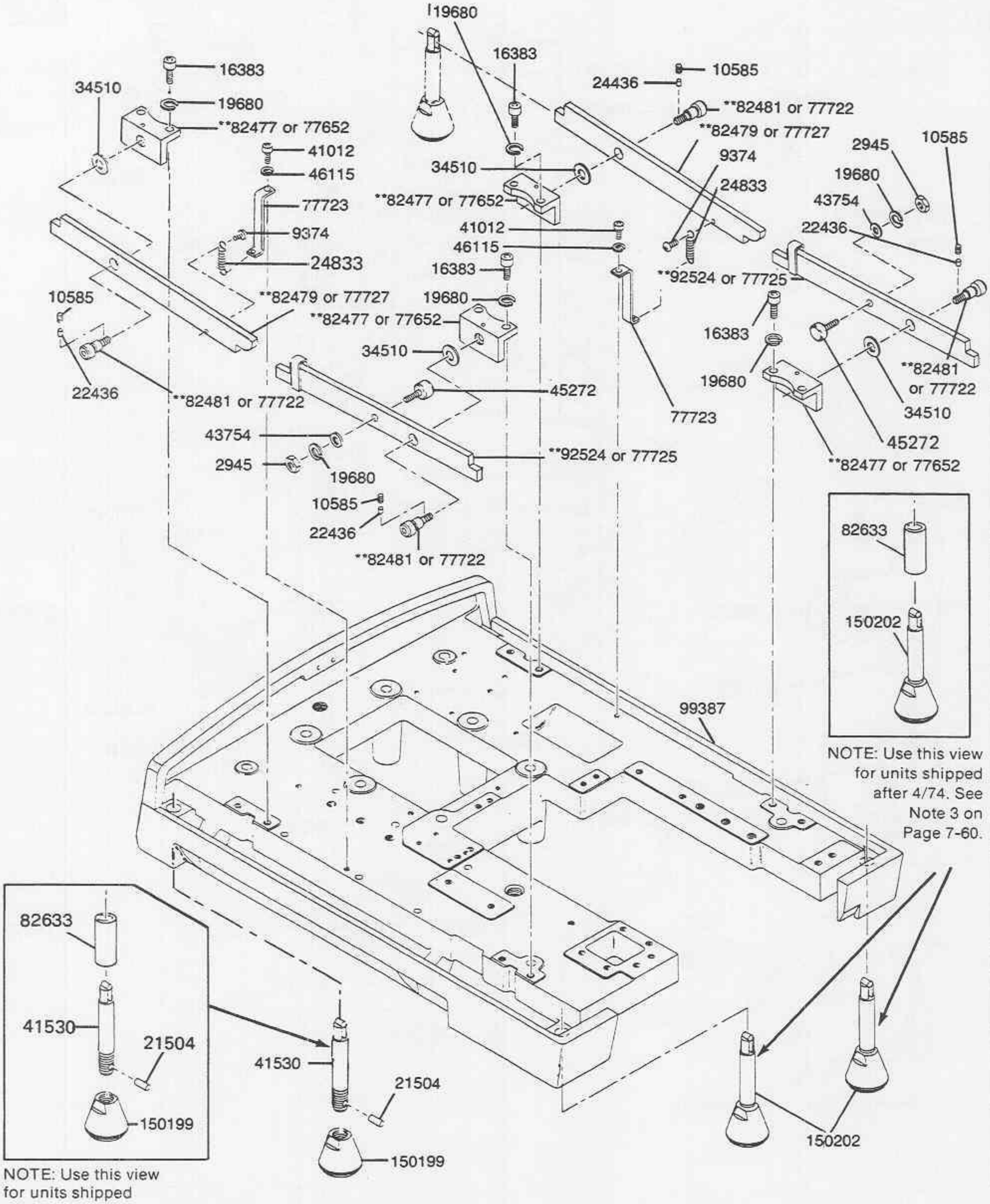
46572

Figure 7-21. TABLE SUPPORT ASSEMBLY (N133636-001).

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-21	
	133636-001	TABLE SUPPORT ASSEMBLY	
	16250-091	PIN, Dowel, 3/8 x 1'' LG., Steel	4
	43223-091	SCREW, Oval Pt. Soc., 10-32 x 1/4, Steel	8
	46478-091	LOADING CAM	8
	46485-045	SPACER	4
	46572-091	BEARING, Guiderol	8
	77526-045	SPACER	8
	77527-091	SHAFT BEARING	4
	150823-073	LOCKNUT, Jam 1/2-20 W/Nylon Insert	16
	79781-001	WEAR PLATE	2
	80116-042	SCREW, Oval Point Allen Set, 1/2-20 x 1'', Steel	8
	90383-091	BUMPER	4
	99417-001	SUPPORT WELDMENT	1

Service Bulletin Number						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19680
**82477 or 77652
41012
46115
77723
9374
24833
10585
**82479 or 77727
22436
**82481 or 77722
16383
24436
10585
**82481 or 77722
**82479 or 77727
34510
9374
24833
**82477 or 77652
41012
46115
16383
19680
**82477 or 77652
34510
**92524 or 77725
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19680
43754
22436
45272
43754
2945
19680
**92524 or 77725
10585
22436
**82481 or 77722
16383
19680
77723
**82481 or 77722
34510
45272
**82477 or 77652
82633
150202
99387
82633
41530
21504
150199
41530
21504
150199
150202

NOTE: Use this view for units shipped after 4/74. See Note 3 on Page 7-60.

NOTE: Use this view for units shipped after 4/74. See Note 3 on Page 7-60.

LUB.

**82479 or 77727

**92524 or 77725

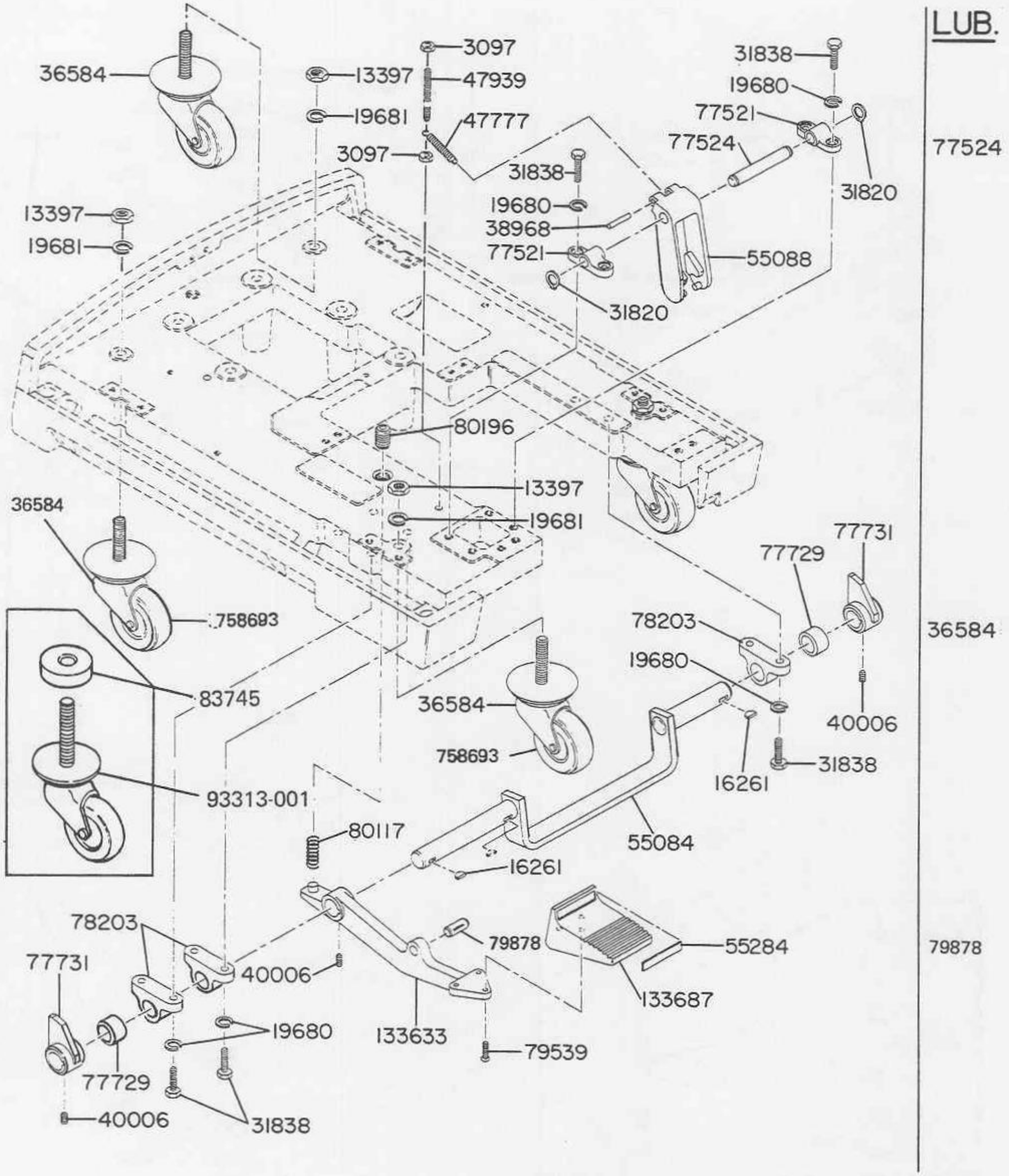
41530

Figure 7-22. FLOOR LOCK ASSEMBLY (99929-001*) (Sheet 1 of 2).

*See Note 1 on Page 7-60.

**See Parts List on Page 7-59 and Note 2 on Page 7-60.

Service Bulletin Number						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77521
55088
31820
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36584
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31838
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80117
16261
78203
77731
40006
79878
55284
133687
19680
133633
79539
77729
40006
31838

Figure 7-22. FLOOR LOCK ASSEMBLY (99929-001*) (Sheet 2 of 2).

*See Note 1 on Page 7-60.

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-22	
NOTE 1	99929	FLOOR LOCK ASSEMBLY	
		(Sheet 1 of 2)	
	2945-041	NUT, Hex., 3/8-24 x 1/4 Thickness, Brass	2
	9374-041	SCREW, RD. HD. Mach., 10-32 x 3/8 LG., Brass	4
	10585-041	SCREW, Set, Allen Cup Point, 10-32 x 1/4, Steel	7
	16383-045	SCREW, Soc. HD. Cap, 3/8-16 x 1'' LG., Steel	4
	19680-041	LOCKWASHER, 3/8, Steel	31
	21504-091	RUBBER CYLINDER	4
	22436-091	PLUG	5
	24833-061	SPRING	2
	34510-091	WASHER, Nylon, 17/32 I.D. x 1'' O.D. x 1/64 Thickness	4
	41012-061	SCREW, Soc. HD. Cap., 10-32 x 1/2, Stainless Steel	4
	41530-045	PIN ASSEMBLY	4
	43754-045	WASHER, 5/8 O.D. x .120 Wall x 1/8 Thickness, Steel	2
	45272-091	BEARING, Cam Follower	2
	46115-091	LOCKWASHER, 10, Steel	5
NOTE 2	77652	BRACKET, Floor Lock Mounting (Units Shipped Before 7/73)	4
NOTE 2	77722-042	SCREW, Shoulder (Units Shipped Before 7/73)	4
	77723-061	SUPPORT, Return Spring	2
NOTE 2	77725	GUIDE, Floor Lock (Units Shipped Before 7/73)	2
NOTE 2	77727	BAR, Floor Lock (Units Shipped Before 7/73)	2
	82477-001	BRACKET, Floor Lock Mounting (Units Shipped After 7/73)	4
	82479-001	BAR, Floor Lock (Units Shipped After 7/73)	2
	82481	SCREW, Shoulder (Units Shipped After 7/73)	4
NOTE 3	82633-001	BEARING, Sleeve, Oilite (Units Shipped After 4/74)	4
	92524-001	GUIDE, Floor Lock (Units Shipped After 7/73)	2
	99387	BASE — See 141172-001	1
	150199-001	FOOT	4
	150202-001	PIN AND FOOT ASSEMBLY	4
		(Sheet 2 of 2)	
	3097-041	NUT, Hex., 1/4-20, Steel	2
	13397-041	NUT, Hex, 1/2-13 x 5/16 Thickness, Brass	4
	16261-091	WOODRUFF KEY, 90, Steel	8
	19680-041	LOCKWASHER, 3/8 Steel	31
	19681-045	LOCKWASHER, 1/2, Steel	4
	31820-091	RING, Retaining, Waldes Truarc, 5100-50	2
	31838-042	SCREW, Hex., HD. Cap, 3/8-16 x 1'', Steel	10
	36584-091	CASTER	4
	38968-061	PIN, Roll, 1/4 x 1/2 LG., Steel	1
	40006-061	SCREW, Set, Allen Cup Point, Nylock, 1/4-20 x 5/16, Stainless Steel	3
	47777-091	SPRING	1
	47939-045	STUD, 1/4 Dia., Stainless Steel	1
	55084-010	FLOOR LOCK SHAFT	1
	55088-091	FLOOR LOCK LATCH	1
	55284-001	NAMEPLATE	1
	77521-091	FLOOR LOCK BEARING	1

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
		FIGURE 7-22 (Sheet 2 of 2)	
	77524-045	FLOOR LOCK SHAFT	1
	134064-001	LIFT CAM ASSEMBLY	1
	77729-045	• SPACER FLOOR LOCK	2
	77731-001	• FLOOR LOCK, Lift Cam	2
	78203-091	• BEARING FLOOR LOCK	3
	79539-010	• SCREW, FL. HD., Soc. Cap, 10-24 x 5/8, Steel	3
	79878-001	• PIN, Grooved, 1/2 x 1-1/4 LG., ASA Type "E," Steel	1
	80117-091	SPRING	1
	80196-045	SCREW, Set, Cup Point, Allen, 7/8-14 x 1, Steel	1
	133633-010	PEDAL LOCK	1
	133687-010	PEDAL	1
NOTE 4	758693-091	WHEEL, 1-15/16" Tread Width	4
NOTE 4	764320-300	WHEEL, 1-1/2" Tread Width	4
	605504-048	CASTER EXTENSION KIT	
	83745-001	• SPACER	4
	83748-001	• PIN AND FOOT ASSEMBLY	4
	93313-001	• CASTER	4

NOTE 1: 99929-001 used on units shipped before 1/75. 99929-001 deleted and parts transferred to 99931-001 and 150128-001 on units shipped after 1/75.

NOTE 2: Order Kit Q-758113-091 to modify old-style floor locks (units shipped before 7/73).

NOTE 3: Order Kit Q-755380-091 to convert tables without oilite bearings (units shipped before 4/74).

NOTE 4: When ordering replacement wheels, check wheel tread width to determine correct replacement wheel.

Service Bulletin Number						

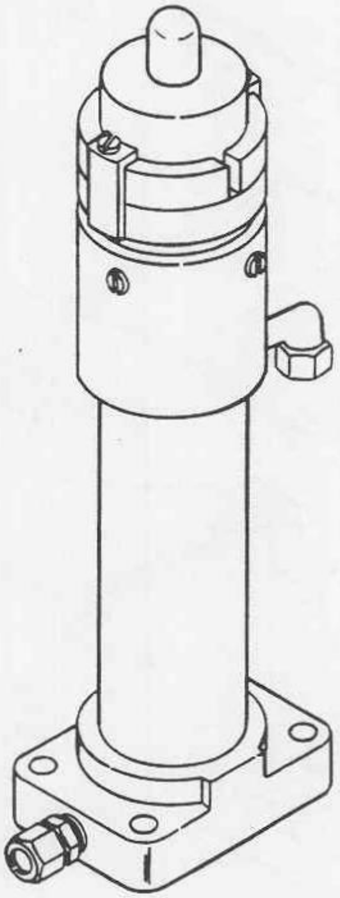
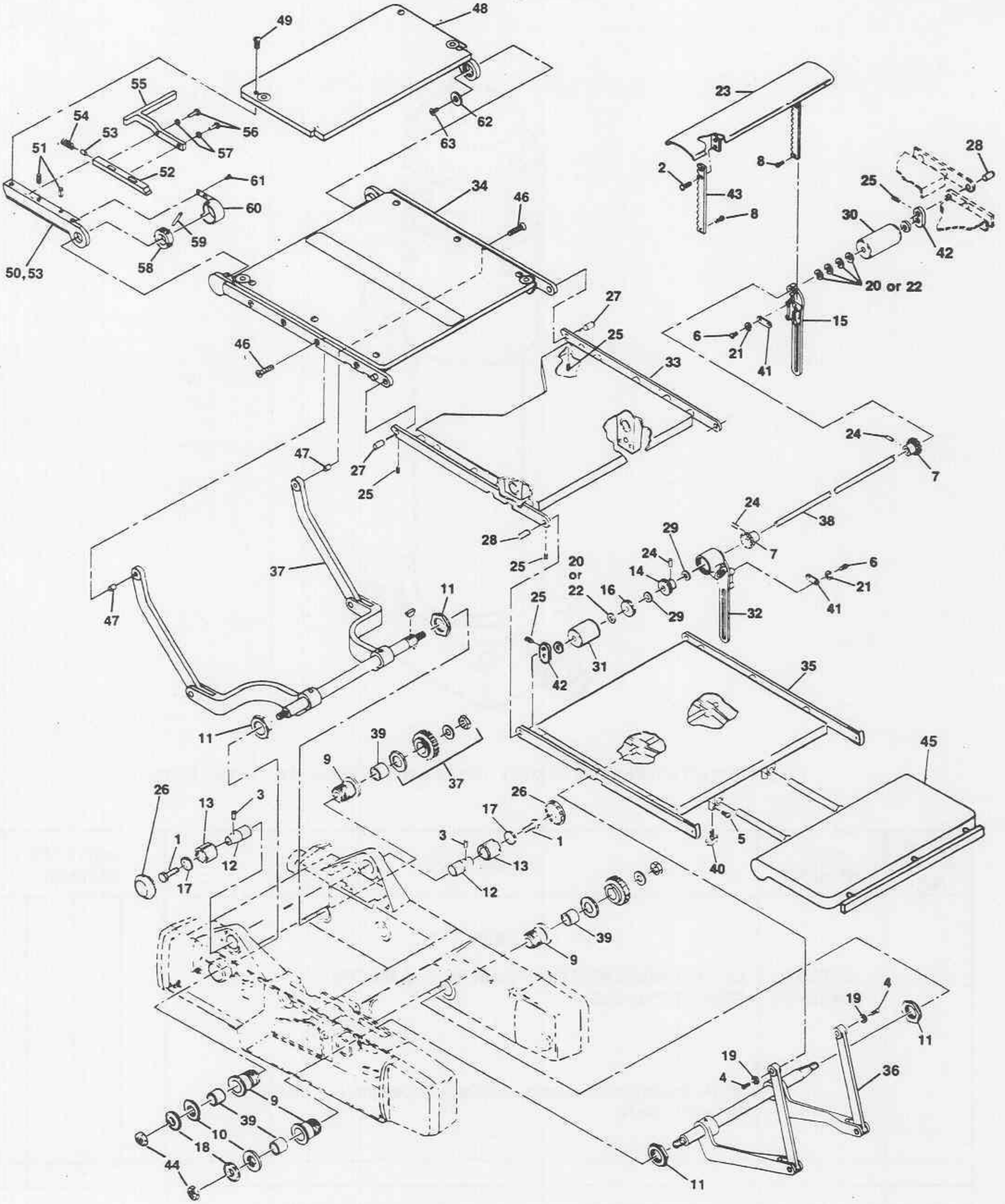


Figure 7-23. LIFT CYLINDER ASSEMBLY (136375-001), UNITS SHIPPED AFTER 7/1/77.

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
		Figure 7-23				
	136375-001	LIFT CYLINDER ASSEMBLY (Units Shipped After 7/1/77)				
	763909-002	REBUILT CYLINDER				
		NOTE: This lift cylinder assembly is not to be rebuilt in the field! Contact Erie for specific details!				

Service Bulletin Number						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11

Figure 7-24. TABLETOP ASSEMBLY — 2080 I.A. MANUAL TABLE*.

**See Figure 7-2 Sheets 2 of 4 and 4 of 4 For Remainder of Tabletop Assembly.*

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
7-24-	146645-509	TABLETOP ASSEMBLY, 2080 I.A. MANUAL TABLE	X
1	3902-041	SCREW, Hex Head, 3/8-16 x 1	2
2	3949-042	SCREW, 1/4-20 x 3/4	4
3	8873-045	PIN, Tube Link	2
4	9282-041	SCREW, Flat Head, 10-32 x 3/8	4
5	9645-061	SCREW, Drive, 4 x 3/16	4
6	12451-041	SCREW, Machine, 6-32 x 1/4	4
7	15220-045	GEAR, Spur	2
8	15324-042	SCREW, Machine, 1/4-20 x 3/8	2
9	16197-045	BUSHING, Eccentric	4
10	16201-091	WASHER, Thrust	2
11	16212-042	LOCKNUT	4
12	16215-091	PIN	2
13	16235-045	BUSHING	2
14	16247-091	GEAR, Worm	1
15	16284-042	STABILIZER	1
16	16285-042	BEARING	1
17	16299-091	WASHER	2
18	16395-091	WASHER, Thrust	2
19	16438-042	WASHER, Shaft	2
20	16578-045	WASHER	A/R
21	19684-061	LOCKWASHER	4
22	20197-045	SPACER	A/R
23	56397-015	ELEVATOR, Kidney	1
24	24700-061	PIN, Groove	3
25	25834-091	SETSCREW	6
26	26577-002	BUTTON, Plug	2
27	43337-063	PIN, Hinge	2
28	44440-063	PIN, Hinge	2
29	50713-091	BEARING, Thrust	2
30	52715-091	SPACER	1
31	52716-091	SPACER	1
32	53328-042	BOX, Gear	1
33	55100-091	SEAT SECTION ASSEMBLY (See Fig. 7-4)	1
34	146645-216	LEG SECTION ASSEMBLY (See Fig. 7-7)	1
35	55105-091	BACK SECTION ASSEMBLY (See Fig. 7-5)	1
36	55114-001	BACK SECTION LEVER ARM ASSEMBLY (See Fig. 7-8)	1
37	136800-702	LEG SECTION LEVER ARM ASSEMBLY (See Fig. 7-25)	1
38	76253-063	SHAFT, Cross	1
39	77555-091	SLEEVE	4
40	77559-056	KNOB ASSEMBLY	2
41	77730-061	BAR, Gear Rack	2
42	78200-052	LINK	2
43	78316-042	RACK	2
44	150092-001	LOCKNUT	2
45	133688-001	HEADREST ASSEMBLY (See Fig. 7-6)	1
46	129357-095	SCREW, Flat Head Socket, 5/16-18 x 1-1/4	2
47	129357-092	BEARING, Sleeve, 5/16 I.D. x 7/16 O.D. x 7/16	2

Service Bulletin Number						

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
7-24-48	146645-215	HEAD/FOOT SECTION ASSEMBLY	1			
49	150055-001	• SCREW, Truss Head, 1/4-20 x 7/8	4			
50	146645-512	• SUPPORT, L.H.	1			
51	45605-061	• PIN, Roll, 1/4 Dia. x 3/4	2			
52	93902-116	• PAWL	1			
53	45741-061	• PIN, Roll, 1/4 Dia. x 1/2	2			
54	36749-045	• SPRING, 17/64 I.D. x 11/32 O.D. x 1	1			
55	136800-700	• HANDLE	1			
56	78025-042	• SCREW, Button Head Socket, #8-32 x 7/8	2			
57	79588-001	• LOCKWASHER, #8, Internal Tooth	2			
	56397-064	• TOP, Head/Foot Section (Not Shown)	1			
	129357-090	• TOP, Insert (Not Shown)	2			
	129357-099	• HOOK FASTENER (Not Shown)	1			
	136800-698	• RIGHT HAND HEAD/FOOT SUPPORT (Not Shown)	1			
58	93902-117	RATCHET	1			
59	36786-061	PIN, Roll, 1/4 Dia. x 1-3/4	1			
60	93902-121	COVER, Weldment	1			
61	45176-044	SCREW, Flat Head, #4-40 x 1/4	2			
62	129357-091	WASHER, Special	1			
63	51580-061	SCREW, Flat Head Socket, 1/4-20 x 3/8	1			

Service Bulletin Number						

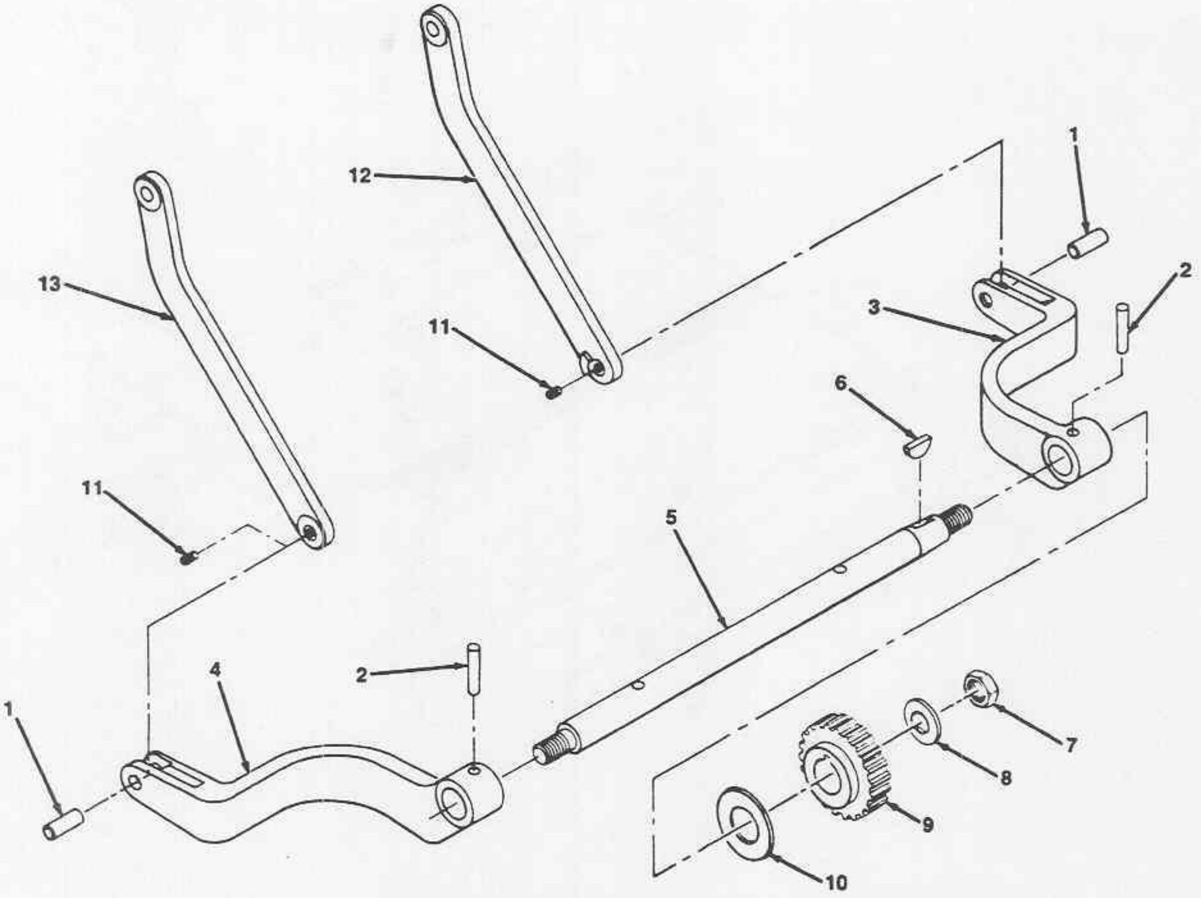


Figure 7-25. LEG SECTION LEVER ARM ASSEMBLY (2080 I.A. TABLE).

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
7-25-	136800-702	LEVER ARM ASSEMBLY — 2080 I.A. TABLE	X			
1	16266-063	PIN, .498 Dia. x 1-1/4..	2			
2	15300-041	PIN, Taper, #6 x 1-3/4	2			
3	136800-693	LEVER ARM, Lower, R.H...	1			
4	136800-696	LEVER ARM, Lower, L.H...	1			
5	16218-061	SHAFT	1			
6	8301-091	KEY, Woodruff, #808, 1/4 Thk. x 1	1			
7	26028-091	NUT, Stop, 5/16-18	1			
8	15014-091	WASHER, .628 I.D. x 1-1/4 O.D. x 1/8	1			
9	16108-091	GEAR, Worm	1			
10	16201-091	WASHER, Thrust, 1-1/64 I.D. x 2 O.D. x 1/8	1			
11	16918-041	SCREW, Set, #10-32 x 3/8	2			
12	93902-112	LEVER ARM, Upper, R.H...	1			
13	93902-115	LEVER ARM, Upper, L.H...	1			

Service Bulletin Number						

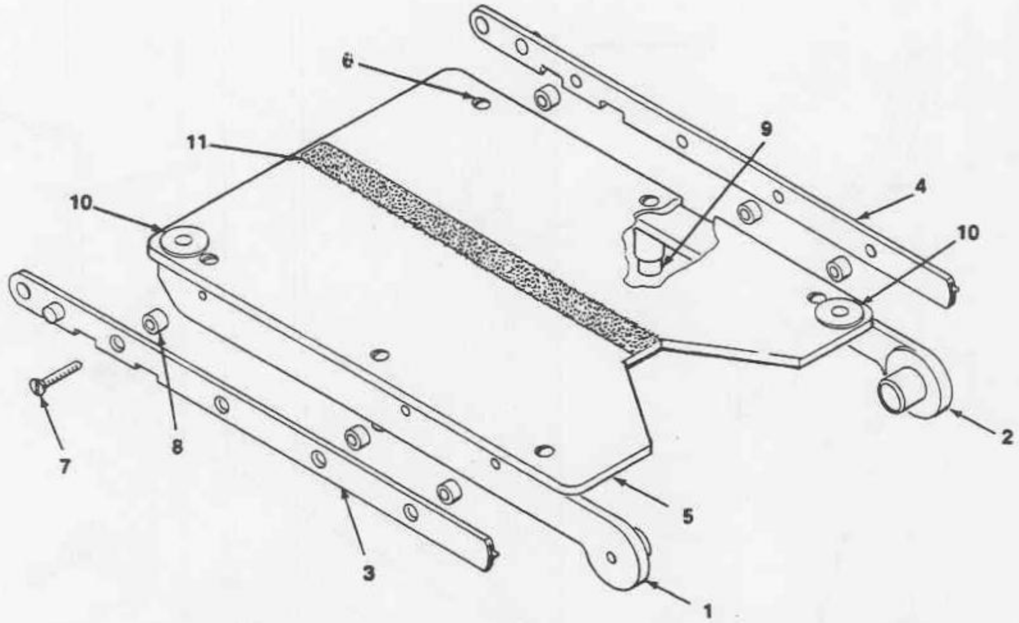
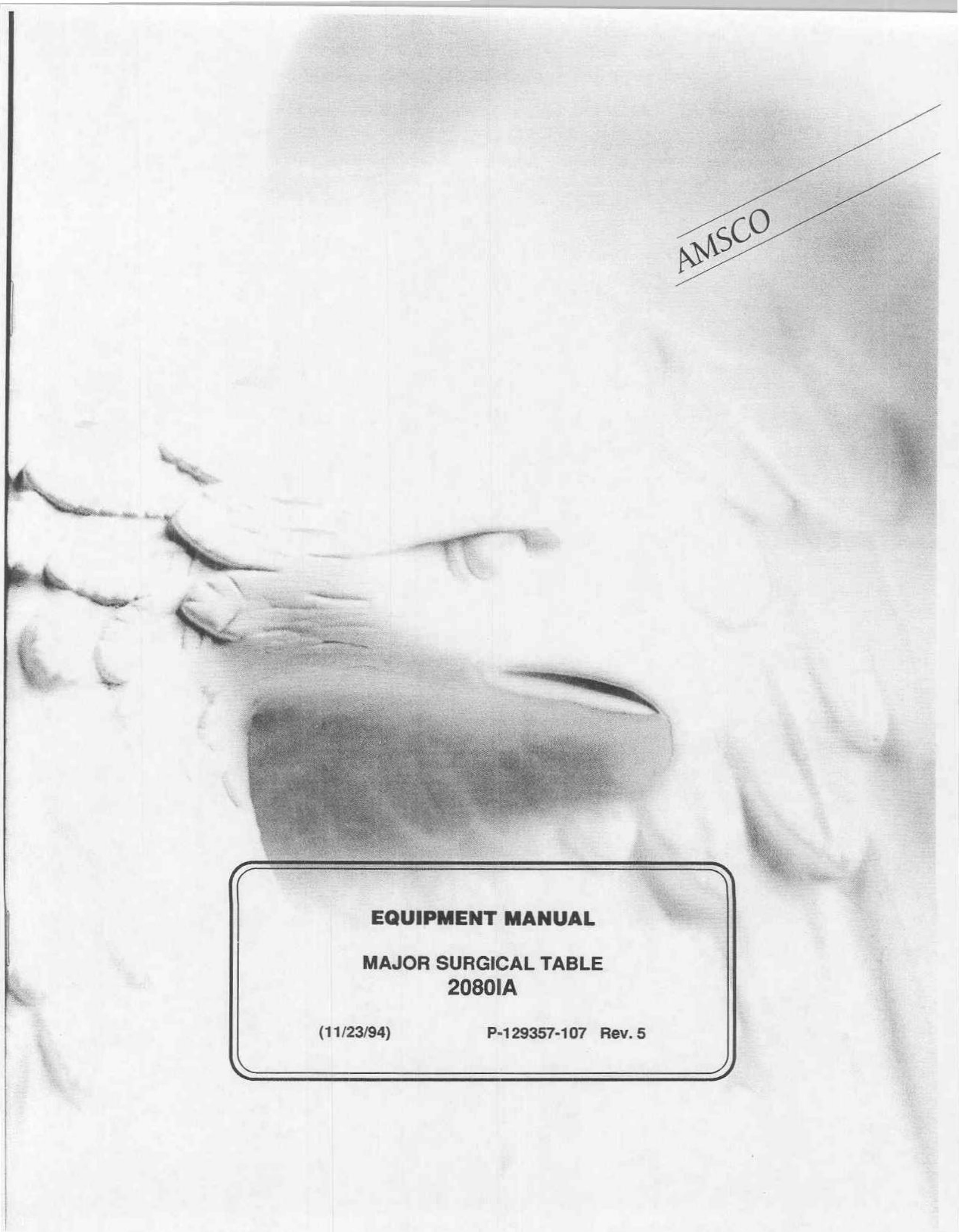


Figure 7-26. LEG SECTION ASSEMBLY (2080 I.A. TABLE).

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
7-26-	146645-216	LEG SECTION ASSEMBLY	X			
1	146645-514	SUPPORT, Leg, R.H.	1			
2	146645-516	SUPPORT, Leg, L.H.	1			
3	136800-703	SIDE RAIL ASSEMBLY, R.H.	1			
4	136800-704	SIDE RAIL ASSEMBLY, L.H.	1			
5	56397-063	TOP, Leg Section	1			
6	150055-001	SCREW, Truss Head, 1/4-20 x 7/8 Lg.	6			
7	129357-095	SCREW, Flat Head Socket, 5/16-18 x 1/4 Lg.	6			
8	15171-042	SPACER	6			
9	19013-091	BUMPER, Rubber	2			
10	129357-090	INSERT, Top	2			
11	43415-091	FASTENER, Hook	1			

Service Bulletin Number						



AMSCO

EQUIPMENT MANUAL

MAJOR SURGICAL TABLE
2080IA

(11/23/94) P-129357-107 Rev. 5

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IMPORTANT: A SUMMARY OF THE SAFETY PRECAUTIONS TO BE OBSERVED WHEN OPERATING THIS SURGICAL TABLE CAN BE FOUND ON PAGE 1. DO NOT OPERATE THE TABLE UNTIL YOU HAVE BECOME FAMILIAR WITH THIS INFORMATION.

EQUIPMENT MANUAL

MAJOR SURGICAL TABLE
2080IA

(11/23/94) **P-129357-107 Rev. 5**

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A WORD FROM AMSCO

This manual contains important information on the proper use and routine care of Model 2080IA Surgical Table. All personnel involved in the use of the table should carefully review and become familiar with the warnings, cautions and instructions found in this manual, and it should be retained in a conveniently accessible area for quick reference.

Following are some important points regarding table operation:

Model 2080IA table is designed to safely support and position a 300-pound patient with floor locks engaged and body weight appropriately distributed to attain standard surgical positions.

The table is furnished with electrically conductive casters and floor locks. Accumulation of certain foreign materials on the surface of these items, and wear over a period of time, can reduce the effectiveness of their conductive properties. We strongly recommend that, before placing the table in use, the resistance level of both the conductive casters and the floor locks be measured according to the requirements of NFPA 99. Subsequent routine testing for conductivity should be performed at least once a month.

A patient grounding receptacle is provided. The male connector for patient grounding is not furnished by AMSCO.

Complete UNCRATING INSTRUCTIONS for this table, as well as an EQUIPMENT DRAWING, have been furnished. If you cannot find them. . .write, fax or telephone AMSCO giving the serial, unit and model numbers of the table. Replacement copies will be sent to you promptly.

Service Information

A thorough preventive maintenance program is essential to safe and proper table operation. Comprehensive instructions for preventive maintenance can be found in the Maintenance Manual, P- 754235-091.

You are encouraged to contact your AMSCO representative concerning our Preventive Maintenance Agreement. Under terms of this agreement, preventive maintenance, adjustments and replacement of worn parts are done on a scheduled basis, assuring equipment performance at peak capability and avoiding untimely or costly operating room schedule interruptions.

AMSCO Engineering Service maintains a nationwide staff of well-equipped, factory-trained technicians to provide this service, as well as expert repair services. Please contact your local AMSCO representative for service details.

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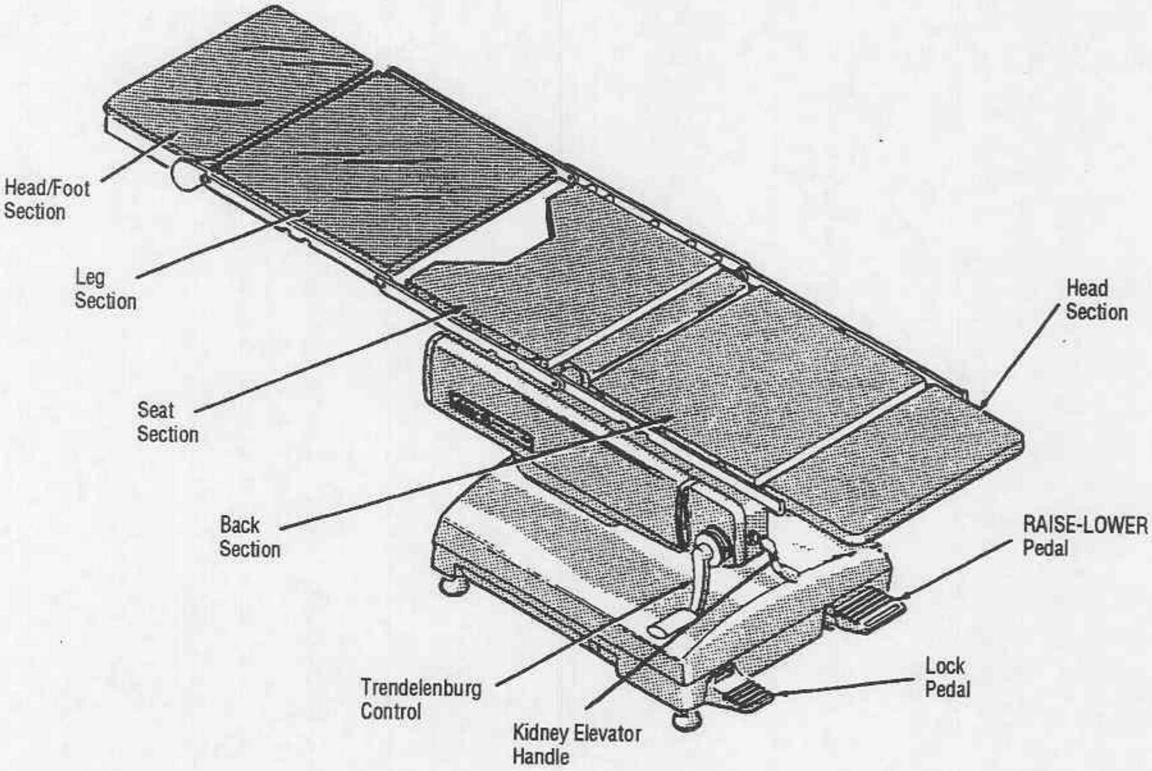

Head/Foot Section
Leg Section
Seat Section
Back Section
Head Section
RAISE-LOWER Pedal
Lock Pedal
Trendelenburg Control
Kidney Elevator Handle

Figure 1. 2080IA Table

SUMMARY OF SAFETY PRECAUTIONS 1

Following is a summary of the safety precautions which must be observed when operating or servicing this table. WARNINGS indicate potential for danger to personnel or patients and CAUTIONS indicate potential for damage to equipment. These precautions are repeated, where applicable, throughout the manual.

WARNING — PINCHING HAZARD:

⚠ **Pinch points are created during extreme tabletop articulation.** Carefully review illustrations in Figure 2, PINCH POINTS, before operating the table.

WARNING — PINCHING AND TIPPING HAZARD:

⚠ **Patient injury may result** if the operator of this table is not completely familiar with the controls for patient positioning and table operation.

WARNING — TIPPING HAZARD:

⚠ **Do not place patient on the table unless floor locks are engaged.**

⚠ **Do not release floor locks while patient is on table.**

⚠ **Do not exceed 300-pound maximum patient weight.**

⚠ **Do not place obese patients (reversed) on the head/foot section, see Figure 5.**

⚠ **Always check table stability when patient is reversed on table.**

WARNING — PATIENT OR USER INJURY HAZARD:

⚠ **Possible patient or user injury**, as well as table or accessory failure, may result from using AMSCO table accessories for other than their stated purpose or from using, on AMSCO tables, accessories manufactured and sold by other companies.

⚠ **Stabilize table when transferring patient.**

⚠ **Unanticipated table movement** could cause patient injury. Patient must be secured to the table in accordance with recommended positioning practices.

⚠ **Health care professionals must ensure** that patients are positioned and monitored so as to prevent compromising respiration, nerve pathways or circulation.

⚠ **When installing any table accessory**, check for correct attachment and tighten securely (if appropriate). Do not use worn or damaged accessory. Check installation before using any accessory.

WARNING — EXPLOSION HAZARD:

⚠ **When used in the presence of flammable anesthetics**, the electrically conductive properties of casters and floor locks must be monitored by trained service personnel. Before placing table in use, measure resistance level of casters and floor locks according to the requirements of NFPA 99. Trained service personnel must perform subsequent routine testing at least once a month.

WARNING — FAILURE HAZARD:

The safe and reliable operation of this equipment requires regularly scheduled preventive maintenance in addition to the faithful performance of the minor maintenance described in this manual. Contact AMSCO Engineering Service to schedule preventive maintenance by an experienced, fully trained service technician.

Repairs and adjustments must be performed only by experienced personnel, fully acquainted with this equipment. Maintenance done by inexperienced, unqualified personnel or installation of unauthorized parts could cause personal injury, invalidate the warranty, or result in costly damage. Contact your AMSCO Engineering Service or sales representative regarding service options.

WARNING — INFECTION HAZARD:

Rubber or plastic gloves, masks and eye protection must be worn and OSHA blood-borne pathogens standards followed when cleaning to protect against aerosols being reflected from contaminated surfaces.

WARNING — PATIENT OR USER INJURY OR EQUIPMENT DAMAGE HAZARD:

When moving the table, do not run the table into solid objects such as doors, doorways, walls, anchored equipment or other heavy equipment. Structural failure may result or damage may occur to the table which may result in later structural failure resulting in personal injury. This damage may not be immediately evident.

CAUTION — PERSONNEL OR EQUIPMENT DAMAGE:

Use only recommended cleaners/disinfectants on AMSCO tables. Do not use phenolics, which may cause patient skin burns if inadequately rinsed off, or alcohol which does not have sufficient cleaning/disinfection properties.

Read the label of aerosol can thoroughly and follow all directions and cautions as shown.

Cleaning procedures requiring articulation of the table should be performed only by persons familiar with table operation.

During some extreme articulations, the tabletop or leg section and leg section lever arms may contact the base and/or column shrouds. Take care to avoid positioning the table in such a way as to cause damage to the shrouds.

After performing cleaning procedures, insure pads and x-ray tops are completely dry before reinstalling. Moisture trapped between pads and x-ray tops may contribute to equipment damage, such as, x-ray top warpage.

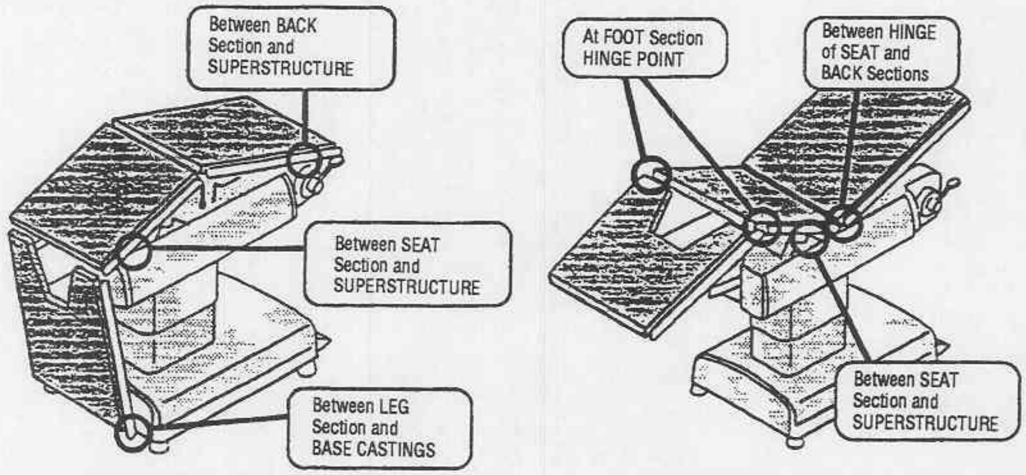
Do not spray cleaning fluid into patient grounding receptacle.

Pinch Points

WARNING - PINCHING HAZARD: Pinch points are created during extreme tabletop articulation. Carefully review illustrations in Figure 2 before operating the table.

During extreme tabletop articulation, eight possible pinch points exist. These points are identified below (see Figure 2).

Attending personnel should examine and be aware of these points before operating the table, and monitor them during patient positioning and table articulation.


Between BACK Section and SUPERSTRUCTURE
Between SEAT Section and SUPERSTRUCTURE
Between LEG Section and BASE CASTINGS
At FOOT Section HINGE POINT
Between HINGE of SEAT and BACK Sections
Between SEAT Section and SUPERSTRUCTURE

(TABLE IN EXTREME FLEX POSITION)

(TABLE IN EXTREME FLEX POSITION)

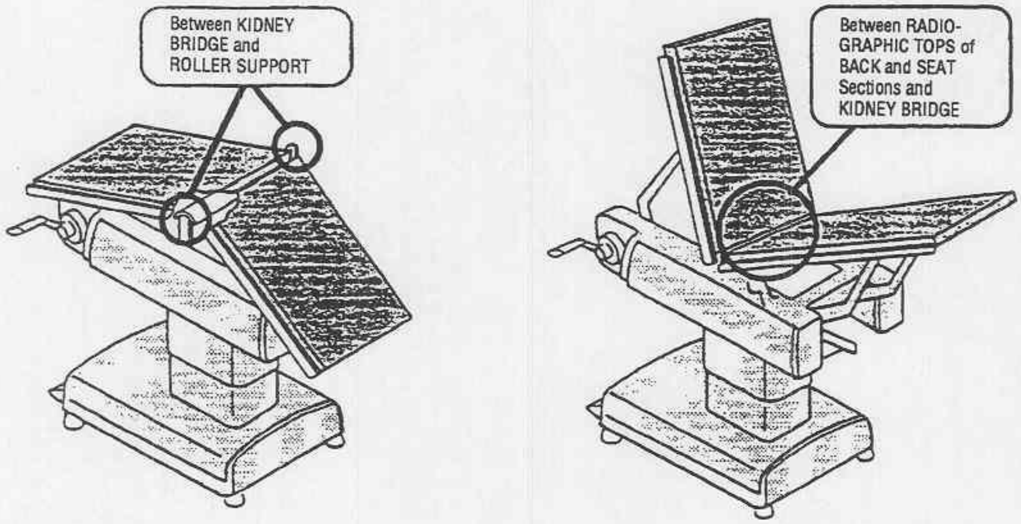

Between KIDNEY BRIDGE and ROLLER SUPPORT
Between RADIO-GRAPHIC TOPS of BACK and SEAT Sections and KIDNEY BRIDGE

Figure 2. Possible Patient Pinch Points

Patient Positioning Requirements

⚠ WARNING - PINCHING AND TIPPING HAZARD: Patient injury may result if the operator of this table is not completely familiar with the controls for patient positioning and table operation.

⚠ WARNING - TIPPING HAZARD:
- Do not place patient on the table unless floor locks are engaged.
- Do not release floor locks while patient is on table.
- Do not exceed 300-pound maximum patient weight.
- Do not place obese patients (reversed) on the head/foot section, see Figure 5.
- Always check table stability when patient is reversed on table.

⚠ WARNING - PATIENT OR USER INJURY HAZARD:
- Stabilize table when transferring patient.
- Health care professionals must ensure that patients are positioned and monitored so as to prevent compromising respiration, nerve pathways or circulation.

This table is designed to safely support and position a 300-pound patient with body weight appropriately distributed to attain standard surgical positions typical of those shown in AMSCO literature. This same design criteria is applied to AMSCO accessories used with this table.

Normal Patient Orientation:

- Do not exceed 300 pounds maximum patient weight.
- Do not use table unless floor locks are engaged.
- Do not attempt to move table while patient is on it.
- Do not extend (lengthen) the patient support surface beyond that shown (refer to Figure 3).
- Have a qualified medical professional monitor patients during surgery for all possible patient positioning hazards.

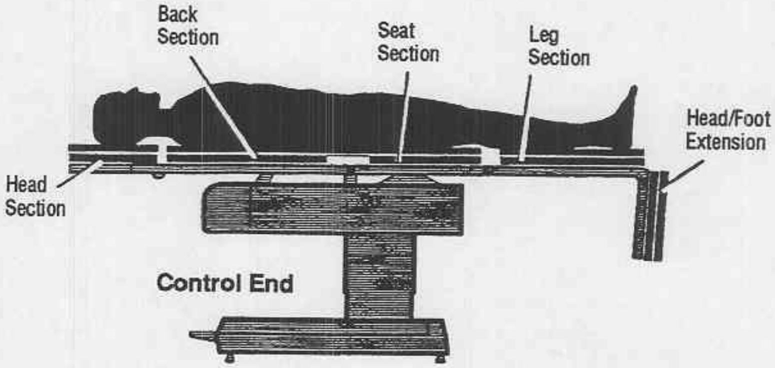


Figure 3. Normal Patient Orientation

⚠ WARNING - PINCHING AND TIPPING HAZARD: Patient injury may result if the operator of this table is not completely familiar with the controls for patient positioning and table operation.

⚠ WARNING - TIPPING HAZARD:

- Do not place patient on the table unless floor locks are engaged.

- Do not release floor locks while patient is on table.

- Do not exceed 300-pound maximum patient weight.

- Do not place obese patients (reversed) on the head/foot section, see Figure 5.

- Always check table stability when patient is reversed on table.

⚠ WARNING - PATIENT OR USER INJURY HAZARD:

- Stabilize table when transferring patient.

- Health care professionals must ensure that patients are positioned and monitored so as to prevent compromising respiration, nerve pathways or circulation.

For Reverse Patient Orientation:

- Observe all normal patient orientation guidelines.
- Do not use head/foot extension for obese patients (see Figure 5).
- Always check table stability when patient is positioned.
- Have a qualified medical professional monitor patients during surgery for all possible patient positioning hazards.

Other Considerations

- Use extreme care when transferring patients to or from table.
- Check that all accessories are properly installed and secured.
- Check for and eliminate harmful patient pressure points once patient is positioned.

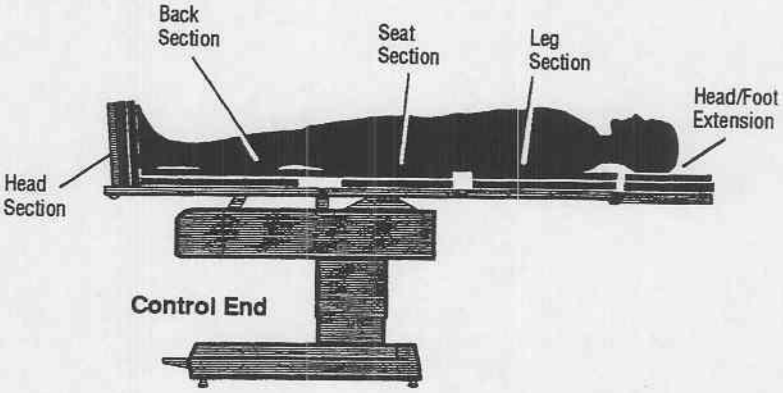

Back Section
Seat Section
Leg Section
Head/Foot Extension
Head Section
Control End

Figure 4. Non-Obese Reverse Patient Orientation

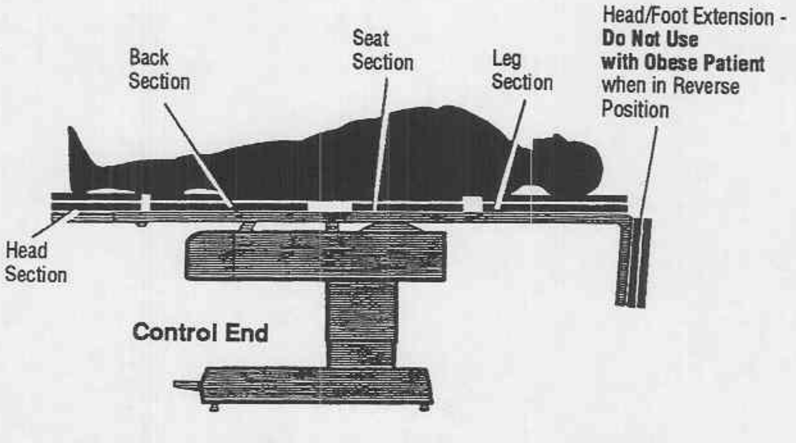

Back Section
Seat Section
Leg Section
Head/Foot Extension - Do Not Use with Obese Patient when in Reverse Position
Head Section
Control End

Figure 5. Obese Reverse Patient Orientation

⚠ **WARNING - EXPLOSION HAZARD: When used in the presence of flammable anesthetics, the electrically conductive properties of casters and floor locks must be monitored by trained service personnel. Before placing table in use, measure resistance level of casters and floor locks according to the requirements of NFPA 99. Trained service personnel must perform subsequent routine testing at least once a month.**

⚠ **WARNING - PATIENT OR USER INJURY OR EQUIPMENT DAMAGE HAZARD: When moving the table, do not run the table into solid objects such as doors, doorways, walls, anchored equipment or other heavy equipment. Structural failure may result or damage may occur to the table which may result in later structural failure resulting in personal injury. This damage may not be immediately evident.**

1. Place table in desired location and measure resistance level of both the conductive casters and floor locks.
2. Fully depress LOCK pedal. (This will lock table in position by lowering the floor locks. The table will remain locked [immobile] until pedal is again fully depressed and then released.)

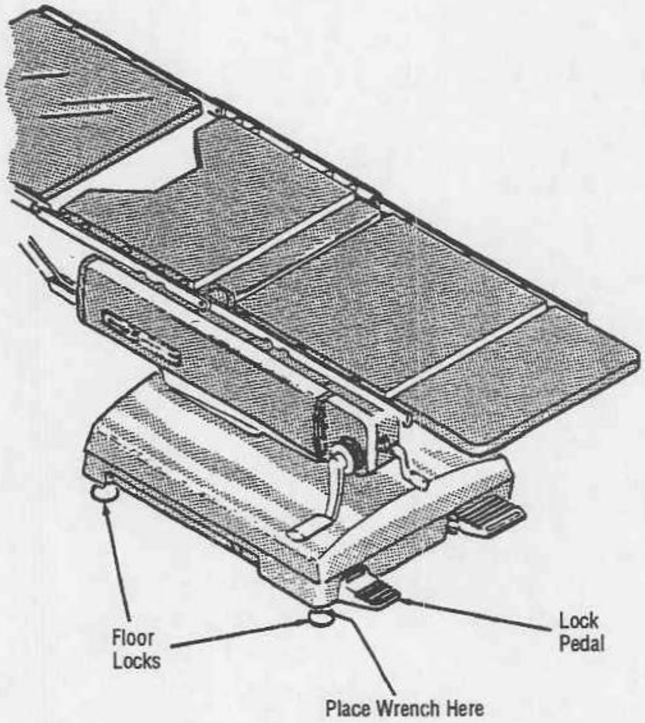


Figure 6. 2080IA Manually Operated Table

3. Check floor locks. Be sure each is snug against floor. If necessary, adjust floor locks as follows.

NOTE: Floor locks are factory-adjusted for a level surface. However, as floor surfaces vary, readjustment may be required. When properly adjusted, locks should engage simultaneously. Casters will not clear floor (i.e., they should not swing freely with table in locked position).

   a. Place LOCK pedal in its up (unlocked) position. Using a wrench, screw floor locks into base as far as possible.

   b. Place LOCK pedal in its down (locked) position. Unscrew floor locks until they are snug against the floor.

   c. Place LOCK pedal in its up position. Unscrew floor locks an additional 1/2 turn.

   d. Operate LOCK pedal through several cycles. Operation should be smooth and positive; table should rise evenly as floor locks are actuated. With locks engaged, table should not rock or move when normal forces are applied. You may also find that a further 1/4 turn in either direction will "fine tune" the operation.

Tabletop Positioning Controls

⚠ WARNING - PINCHING HAZARD: Pinch points are created during extreme tabletop articulation. Carefully review illustrations in Figure 2, PINCH POINTS, before operating the table.

⚠ WARNING - PINCHING AND TIPPING HAZARD: Patient injury may result if the operator of this table is not completely familiar with the controls for patient positioning and table operation.

⚠ WARNING - TIPPING HAZARD:
- Do not place patient on the table unless floor locks are engaged.
- Do not release floor locks while patient is on table.
- Do not exceed 300-pound maximum patient weight.
- Do not place obese patients (reversed) on the head/foot section, see Figure 5.
- Always check table stability when patient is reversed on table.

⚠ WARNING - PATIENT OR USER INJURY HAZARD:
- Possible patient or user injury, as well as table or accessory failure, may result from using AMSCO table accessories for other than their stated purpose or from using, on AMSCO tables, accessories manufactured and sold by other companies.
- Stabilize table when transferring patient.
- Unanticipated table movement could cause patient injury. Patient must be secured to the table in accordance with recommended positioning practices.

All controls are conveniently located at the table head end. Two easy-to-operate crank handles provide complete maneuverability of the tabletop. The BACK-SIDE-FOOT-FLEX control is on the right side ... the TRENDELENBURG/REVERSE TRENDELENBURG (see Figure 7) control is on the left. Both handles are within easy reach of the anesthesiologist and may be operated simultaneously, if desired. A clearly labeled foot pedal allows the table to be RAISED or LOWERED throughout an 18" range.

NOTE: A patient grounding receptacle (Fig. 7) is provided in accordance with NFPA99. Male connector to ground patient is not furnished by AMSCO.

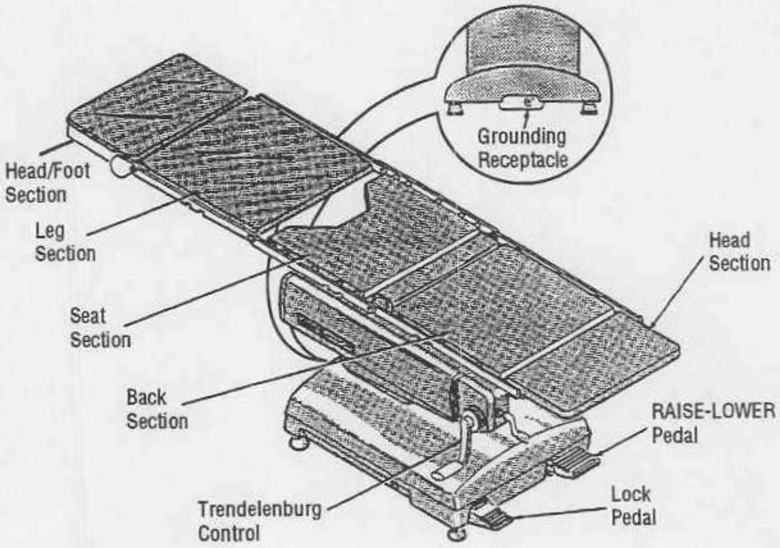


Figure 7. Identification of Table Controls

⚠ **WARNING - PATIENT OR USER INJURY HAZARD (continued):**

- Health care professionals must ensure that patients are positioned and monitored so as to prevent compromising respiration, nerve pathways or circulation.

- When installing any table accessory, check for correct attachment and tighten securely (if appropriate). Do not use worn or damaged accessory. Check installation before using any accessory.

⚠ **WARNING - PATIENT OR USER INJURY OR EQUIPMENT DAMAGE HAZARD: When moving the table, do not run the table into solid objects such as doors, doorways, walls, anchored equipment or other heavy equipment. Structural failure may result or damage may occur to the table which may result in later structural failure resulting in personal injury. This damage may not be immediately evident.**

⚠ **CAUTION: During some extreme articulations, the tabletop or leg section and leg section lever arms may contact the base and/or column shrouds. Take care to avoid positioning the table in such a way as to cause damage to the shrouds.**

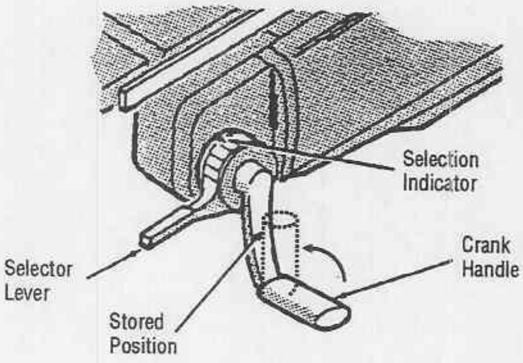


Figure 8. Posture Selector

Back-Side-Foot-Flex Control (See Figure 8)

1. Move Selector Lever to BACK, SIDE, FOOT or FLEX.
2. Turn Crank Handle until the desired angulation is achieved. (Direction that crank is turned will govern direction of tabletop movement.)
3. Releasing the Crank Handle automatically stops the tabletop and locks it in position.
4. Handle can be placed in the stored position by pulling straight out and then pivoting the handle.

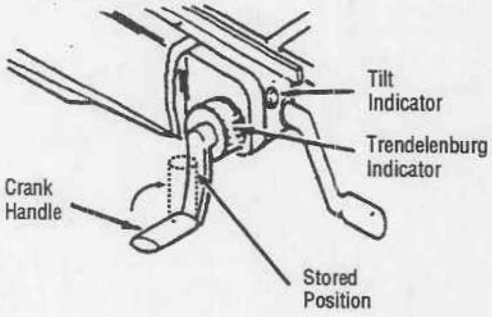

Tilt
Indicator
Trendelenburg
Indicator
Crank
Handle
Stored
Position

Figure 9. Trendelenburg Control

Trendelenburg/Reverse Trendelenburg Control (See Figure 9)

1. Turn Crank Handle clockwise for Trendelenburg positioning... counter-clockwise for Reverse Trendelenburg.
2. Releasing the Crank Handle automatically stops the tabletop and locks it in position.
3. Handle can be placed in the stored position by pulling straight out and then pivoting the handle.

NOTE: An easy-to-read Tilt Indicator shows the degree of angulation.

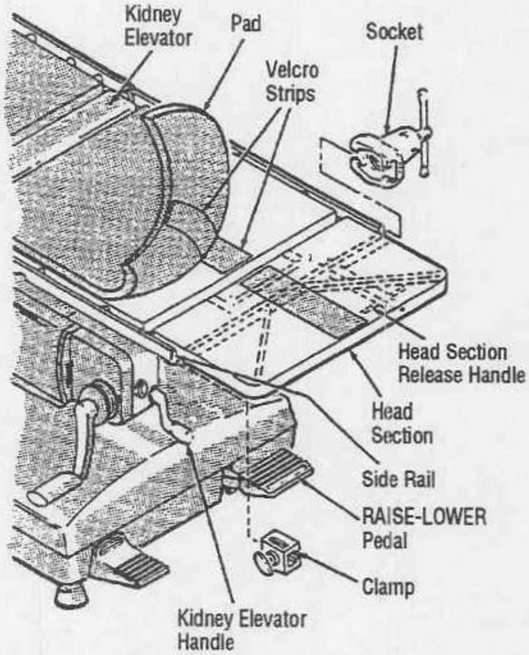

Kidney
Elevator
Pad
Socket
Velcro
Strips
Head Section
Release Handle
Head
Section
Side Rail
RAISE-LOWER
Pedal
Clamp
Kidney Elevator
Handle

Figure 10. Table Head End

Raise-Lower Control (See Figure 10)

1. Pump Foot Pedal to elevate tabletop ... depress fully to lower.
2. Releasing the pedal automatically stops tabletop and locks it in position.

Head Section Control (See Figure 10)

The head section has a Position-control Ratchet beneath the head section.

1. Pull the Release Handle (spring loaded) toward the table head end.
2. Place the head section in desired position.
3. Release the Handle to lock the head section in position.

Kidney Elevator Control (See Figure 10)

The Kidney Elevator Crank Handle is adjacent to the Trendelenburg Crank Handle.

Turn Crank Handle clockwise to raise kidney elevator ... counter-clockwise to lower.

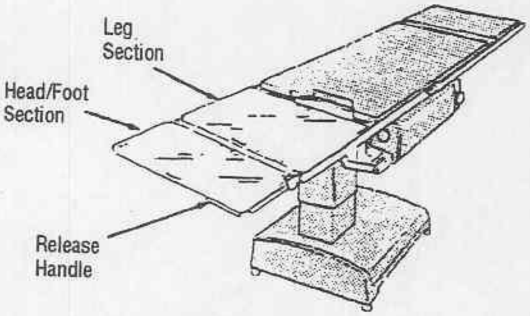


Figure 11. Table Foot End

Head/Foot Section Control (See Figure 11)

1. Pull Release Handle (spring loaded) towards table leg end.
2. Place head/foot section in desired position.
3. Release Handle to lock head/foot section in position.
4. For storage convenience, the head/foot section can be rotated and locked beneath the leg section.

Pads And Accessories

⚠ WARNING - PATIENT OR USER INJURY HAZARD:

- Possible patient or user injury, as well as table or accessory failure, may result from using AMSCO table accessories for other than their stated purpose or from using, on AMSCO tables, accessories manufactured and sold by other companies.

- When installing any table accessory, check for correct attachment and tighten securely (if appropriate). Do not use worn or damaged accessory. Check installation before using any accessory.

Pads (See Figure 10)

The conductive rubber mattress pads are backed with Velcro® strips which fasten to opposing strips on the tabletop.

1. To install, place pad in position and press Velcro strips together.
2. To remove, "peel" pad away from tabletop.

Accessories (See Figure 10)

Removable accessories are positioned and secured by clamps or sockets which are applied to (and slide along) the side rails.

1. To install, place clamp (or socket) on side rail and lock in position with knob (or handle) provided.
2. To remove clamp (or socket) from side rail, loosen knob (or handle) and slide clamp (or socket) along rail until a notch is reached ... then remove clamp. (Note: Clamp or socket may also be, removed from end of side rail by lowering the stop.)
3. If table includes X-ray top, refer to P-79779-001, Equipment Instructions (supplied with top) for proper installation procedure.

®Velcro Corporation

ROUTINE MAINTENANCE

WARNING - FAILURE HAZARD: The safe and reliable operation of this equipment requires regularly scheduled preventive maintenance in addition to the faithful performance of the minor maintenance described in this manual. Contact AMSCO Engineering Service to schedule preventive maintenance by an experienced, fully trained service technician.

Perform the following procedures at regular intervals, as indicated. This frequency is the minimum and should be increased with increased usage of the table.

A Preventive Maintenance Agreement is available where maintenance, adjustments, and replacement of worn parts are performed by a qualified technician on a scheduled basis to assure peak equipment performance and avoid unscheduled downtime. Contact your AMSCO representative.

Expanded maintenance procedures require reference to the MAINTENANCE MANUAL, P-754235-091, and should be performed **only** by a qualified technician.

IMPORTANT: If table is to be placed in extended storage, have table prepared for storage by a qualified service technician.

Daily Cleaning/ Disinfecting Procedures

WARNING - INFECTION HAZARD: Rubber or plastic gloves, masks and eye protection must be worn and OSHA blood-borne pathogens standards followed when cleaning to protect against aerosols being reflected from contaminated surfaces.

WARNING - PATIENT OR USER INJURY OR EQUIPMENT DAMAGE HAZARD: When moving the table, do not run the table into solid objects such as doors, doorways, walls, anchored equipment or other heavy equipment. Structural failure may result or damage may occur to the table which may result in later structural failure resulting in personal injury. This damage may not be immediately evident.

CAUTION:
- Use only recommended cleaners/ disinfectants on AMSCO tables. Do not use phenolics, which may cause patient skin burns if inadequately rinsed off, or alcohol which does not have sufficient cleaning/disinfection properties.

Materials Needed:

- Several clean, dry, lint free cloths
- Can of AMSCO OR/CS Spray N' Wipe Cleaner (Reorder #NK351, P-400000-721)*
- Container of clean water

NOTE: When using disinfectants, manufacturer's label recommendations must be followed.

Post-Usage Cleaning Procedure

1. Remove gross soil with a disposable cloth and place used cloth in an appropriate biohazardous waste disposal container.
2. Clean tabletop as follows:
   a. Articulate tabletop to level condition and place at a comfortable working height (See caution at left).
   b. Remove tabletop pads by pulling up to free them from Velcro fasteners and place on another table or flat surface.
   c. Hold can 6-8 inches from surface and spray cleaning fluid liberally on top and sides of pads. (It is recommended to clean only one pad at a time.)
   d. Wipe sprayed surfaces with a clean lint free cloth dampened with water to remove cleaning fluid (dampening cloth will minimize streaking).
   e. Wipe the cleaned surfaces again with a clean damp lint free cloth to remove residue.
   f. Repeat steps c, d and e for bottom of pads. Repeat steps c, d and e for tabletop surfaces exposed when pads are removed. Thoroughly dry bottom of pads and tabletop surfaces.
   g. Place pads back onto tabletop by aligning with sides of table and pressing into place on the Velcro fasteners.

**Available from your local AMSCO representative.*

▲ CAUTION (continued):

- Read the label of aerosol can thoroughly and follow all directions and cautions as shown.

- Cleaning procedures requiring articulation of the table should be performed only by persons familiar with table operation.

- After performing cleaning procedures, insure pads and x-ray tops are completely dry before reinstalling. Moisture trapped between pads and x-ray tops may contribute to equipment damage, such as, x-ray top warpage.

- Do not spray cleaning fluid into patient grounding receptacle.

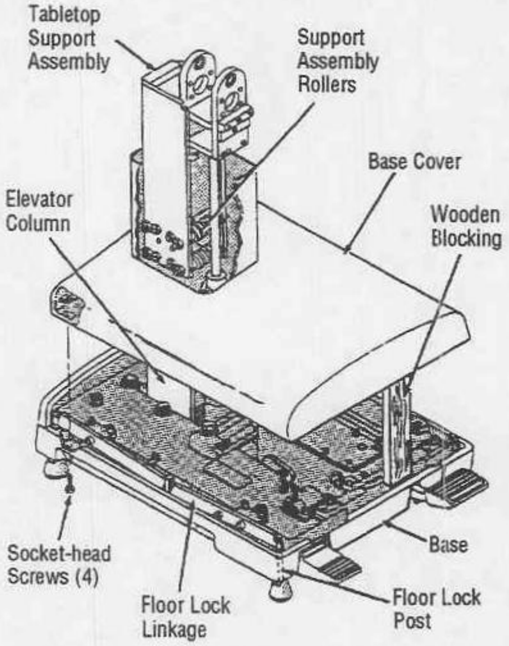


Figure 12. Base Assembly

3. Raise table to maximum height to access lower surfaces.
4. Clean column cap and shrouds, and entire base surface as follows:
   a. Hold can 6-8 inches from surface and spray cleaning fluid liberally on column cap and shrouds.
   b. Wipe sprayed surfaces with a clean cloth dampened with water to remove cleaning fluid (dampening cloth will minimize streaking).
   c. Wipe the cleaned surfaces again with a clean damp lint free cloth to remove residue.
   d. Repeat steps a, b and c for base surface.

End-of-Day Cleaning Procedure

1. Perform all steps of the post-usage cleaning procedure.
2. Check table casters for any accumulated debris. Clean casters and check for conductivity per NFPA 99 requirements (see Warning, page 6).

Weekly Cleaning Procedure

1. Perform steps 1-4 of the post-usage cleaning procedure. Perform step 2 of the end-of-day cleaning procedure.
2. Articulate the table through **all** movements and clean all additional exposed surfaces during these articulations:
   a. Hold can 6-8 inches from surface to be cleaned and spray cleaning fluid liberally on surface.
   b. Wipe sprayed surfaces with a clean cloth dampened with water to remove cleaning fluid (dampening cloth will minimize streaking).
   c. Wipe the cleaned surfaces again with a clean damp lint free cloth to remove residue.

Monthly Preventive Maintenance

⚠ **WARNING - EXPLOSION HAZARD: When used in the presence of flammable anesthetics, the electrically conductive properties of casters and floor locks must be monitored by trained service personnel. Before placing table in use, measure resistance level of casters and floor locks according to the requirements of NFPA 99. Trained service personnel must perform subsequent routine testing at least once a month.**

⚠ **WARNING - FAILURE HAZARD:**
- The safe and reliable operation of this equipment requires regularly scheduled preventive maintenance in addition to the faithful performance of the minor maintenance described in this manual. Contact AMSCO Engineering Service to schedule preventive maintenance by an experienced, fully trained service technician.
- Repairs and adjustments must be performed only by experienced personnel, fully acquainted with this equipment. Maintenance done by inexperienced, unqualified personnel or installation of unauthorized parts could cause personal injury, invalidate the warranty, or result in costly damage. Contact your AMSCO Engineering Service or sales representative regarding service options.

⚠ **WARNING - PATIENT OR USER INJURY OR EQUIPMENT DAMAGE HAZARD: When moving the table, do not run the table into solid objects such as doors, doorways, walls, anchored equipment or other heavy equipment. Structural failure may result or damage may occur to the table which may result in later structural failure resulting in personal injury. This damage may not be immediately evident.**

1. Service base assembly as follows (see Figure 12):
   a. Raise tabletop to maximum height.
   b. Remove socket-head screws (1/4") and raise base cover.
   c. Secure base cover in raised position with blocking or by tying to table frame.
   d. Lubricate the following floor lock items with MOLYLITH HD No. 2® or equivalent.
      - Floor lock bar linkage interlocks
      - Floor lock posts and reamed holes in base
      - Bearings, shafts and other moving parts
   e. Clean casters and check for conductivity Per NFPA 99 (see WARNING, page 6).
   f. Inspect base assembly and hydraulic system for any sign of damage and loose or misaligned parts.
   g. Lower and secure base cover.
2. Inspect tabletop assembly for any sign of damage and loose or misaligned parts.

Quarterly Preventive Maintenance

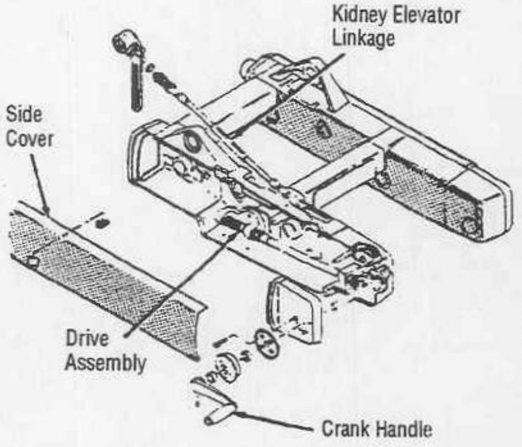

Kidney Elevator Linkage
Side Cover
Drive Assembly
Crank Handle

Figure 13. Trendelenburg Drive Assembly

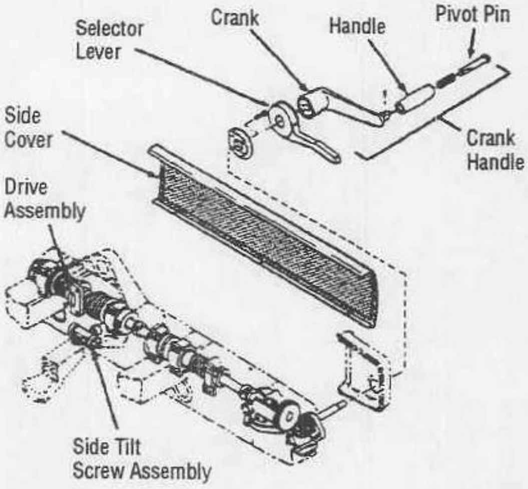

Selector Lever
Crank
Handle
Pivot Pin
Side Cover
Crank Handle
Drive Assembly
Side Tilt Screw Assembly

Figure 14. Posture Drive Assembly

1. Service tabletop drive assemblies as follows (see Figures 13 and 14):
   a. Remove side covers.
   b. Examine drive assemblies and linkage for any sign of damage and loose or misaligned parts.
   c. Coat the following drive assembly items (both sides of table) with MOLYLITH HD No. 2 or equivalent.
      - Gears, worms and gear sectors
      - Bearings, bearing blocks, and shafts
   d. Replace side covers.
2. Disassemble both crank handles (see Figure 13) and apply LUBRIPLATE No. 630 AA® or equivalent to the pivot pins and insides of handles. Reassemble handle on crank.
3. Lubricate side tilt screw assembly, universal joint, shafts and bearings (see Figure 14) with MOLYLITH HD No. 2 or equivalent.
4. Service lift assembly (see Figure 12) as follows:
   a. Raise tabletop to maximum height.
   b. Remove socket-head screws (1/4") and raise base cover.
   c. Secure base cover in raised position with blocking or by tying to table frame.
   d. Coat the two sides of elevator column on which tabletop support assembly rollers **do not** roll with MOLYLITH HD No. 2 or equivalent.
   e. Lubricate tabletop support assembly shafts and bearings with MOLYLITH HD No. 2 or equivalent. (Keep roller sides of elevator column free of lubricant.)
   f. Lower and secure base cover.

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Semi-annual Preventive Maintenance

1. Service kidney elevator and tabletop positioning linkage (see Figure15) as follows:
   a. Coat the following items with LUBRIPLATE No. 630 AA or equivalent.
      - Kidney elevator gears
      - Headrest cross shaft and ratchet lever
      - Head/foot section pivots and ratchet lever

   b. Lubricate the following items with LUBRIPLATE No. 630 AA or equivalent.
      - Kidney elevator shafts
      - Leg and back section cross shafts

   c. Lubricate the following items with a light coat of medium grade lubricating oil.
      - Kidney elevator bearings and universal joints
      - Leg and back section lever arm joints

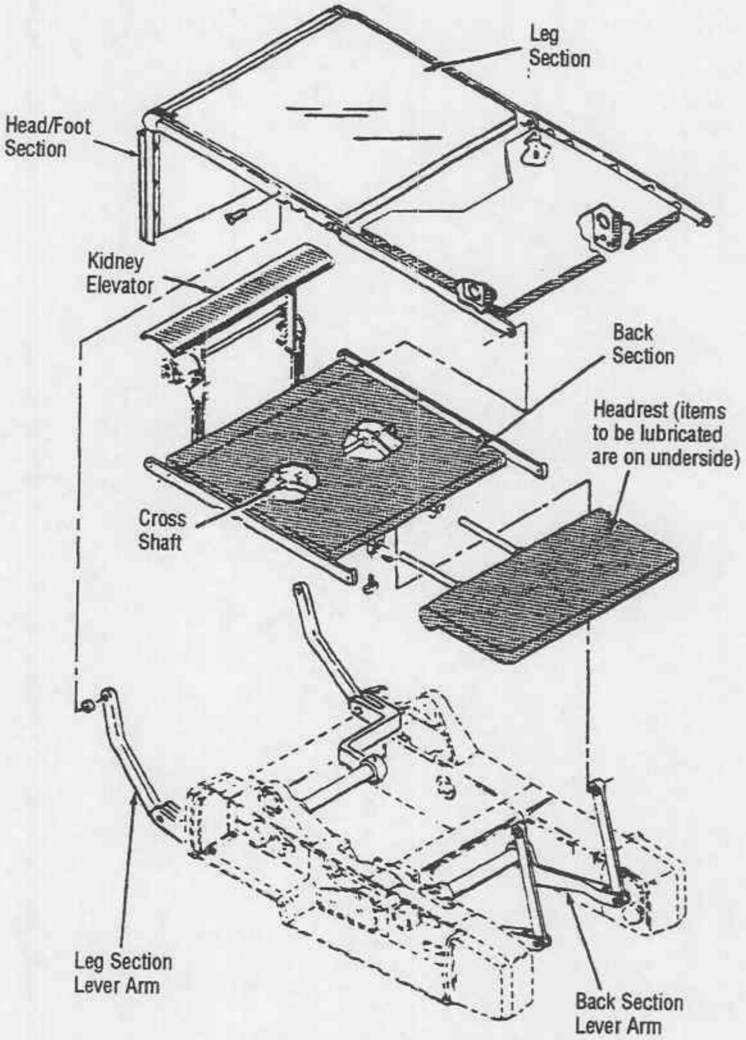
Leg Section
Head/Foot Section
Kidney Elevator
Back Section
Headrest (items to be lubricated are on underside)
Cross Shaft
Leg Section Lever Arm
Back Section Lever Arm

Figure 15. Kidney Elevator and Tabletop Functions

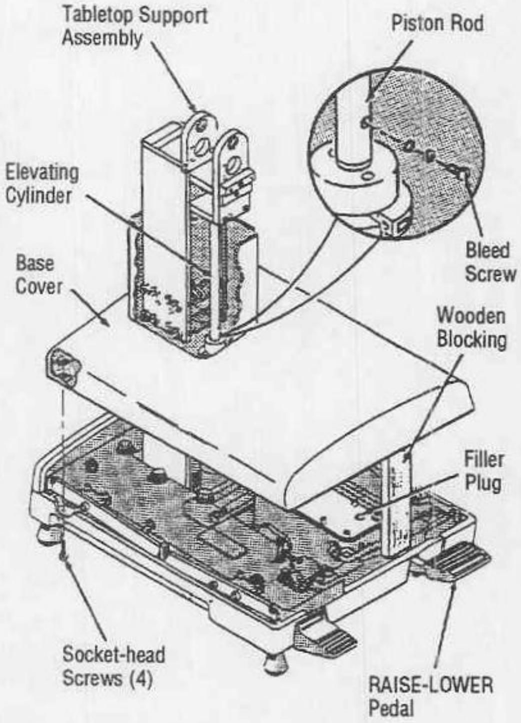

Figure 16. Hydraulic System

2. Move crank handle on posture selector (see Figure 14) to disengage its clutch. Apply a thin coat of LUBRIPLATE No. 630 AA or equivalent to the tapered clutch faces between handle and selector lever.
3. Check oil level and lubricate caster cylinder assemblies (see Figure16) as follows:
   a. Raise tabletop to maximum height.
   b. Remove socket-head screws (1/4") and raise base cover to expose the filter plug.
   c. Secure base cover in raised position with blocking or by tying it to table frame.
   d. Remove filler plug and insert a clean piece of stiff cardboard or similar object into sump to check oil level. Object must touch bottom.
   e. Normal oil level is 1-1/2" from bottom of sump. Add oil if level is 1/8" or more below normal ... replace filler plug. Capacity of the hydraulic system is two quarts; do not overfill. Order and use the AMSCO hydraulic oil indicated on the sump decal.
   f. Inject LUBRIPLATE No. 630AA or equivalent into fittings on sides of casters.
   g. Lower and secure base cover.
4. If oil was added, operate table. If operation is "spongy," bleed hydraulic system as follows:
   a. Raise tabletop to maximum height.
   b. Raise base cover to expose elevating cylinder. Secure cover in raised position.
   c. Loosen bleeding screw (see Figure 16 insert) and pump the RAISE-LOWER pedal. Allow fluid to flow until all trapped air has escaped. Tighten the screw; be sure it is completely recessed in piston rod.
   d. Lower and secure base cover.
   e. Completely lower and then raise tabletop. If any trapped air remains, table will not operate smoothly and entire procedure must be repeated.

Troubleshooting

Please call your local AMSCO representative if you encounter problems other than those mentioned below. The AMSCO representative will promptly arrange to have your table placed in proper working order by a factory-trained service technician.

NOTE: Never permit inexperienced, unqualified persons to attempt to make any repairs on your table.

The following guide is for maintenance personnel when minor problems occur.

1. Check oil level and add oil if necessary (see Semi-Annual Preventive Maintenance, step 3) when tabletop positions slowly, or when tabletop will not elevate to maximum height.
2. Bleed air from hydraulic system (see Semi-Annual Preventive Maintenance, step 4) if tabletop raise function is erratic.